

Garant
**GARANT Diabolo solid carbide ball nose slot drill HPC, TiAlN, Ø f8 DC / DS:
3/6mm**

Order data

Order number	207476 3/6
GTIN	4045197600691
Item class	11X

Description
Version:
GARANT Diabolo:

Special geometry, newly developed coating and carbide for hard machining. 4 centre cutting edges to the centre. Therefore can be used as a true **4-edge drill** at all depths of cut.

Tolerance: Radius contour = ± 0.005 mm.

Technical description

Feed f_z for copy milling in steel < 65 HRC	0.019 mm
No. of teeth Z	4
Feed f_z for side milling in steel < 65 HRC	0.019 mm
Cutting edge $\varnothing D_c$	3 mm
Shank $\varnothing D_s$	6 mm
Overall length L	80 mm
Flute length L_c	5 mm
Correction factor for v_c	1.25
Helix angle	30 degrees
Radius R	1.5 mm
Series	Diabolo
Coating	TiAlN

Tool material	Solid carbide
Standard	Manufacturer's standard
Type	H
Tolerance nominal \varnothing	f8
Direction of infeed	horizontal, oblique and vertical
Cutting width a_e for milling operation	0.05×D for copy milling
Cutting width a_e for milling operation	0.2×D for side milling
Shank	DIN 6535 HA to h6
Through-coolant	no
Machining strategy	HPC
Colour ring	red
Type of product	Ball-nosed slot drill

User data

	Suitability	V_c	ISO code
Steel < 1400 N/mm ²	suitable	200 m/min	P
Steel < 50 HRC	suitable	190 m/min	H
Steel < 55 HRC	suitable	170 m/min	H
Steel < 60 HRC	suitable	150 m/min	H
Steel < 65 HRC	suitable	110 m/min	H
wet maximum	suitable only under restricted conditions		
wet minimum	suitable only under restricted conditions		
dry	suitable		
Air	suitable		

Services

Shank grinding Type HB	129100 HB
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