

Garant
**GARANT Diabolo solid carbide ball nose slot drill HPC, TiAlN, Ø f8 DC / DS:
8mm**

Order data

| | |
|--------------|---------------|
| Order number | 207476 8 |
| GTIN | 4045197600752 |
| 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

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|---|---------------|
| Feed f_z for side milling in steel < 65 HRC | 0.06 mm |
| Cutting edge $\varnothing D_c$ | 8 mm |
| No. of teeth Z | 4 |
| Feed f_z for copy milling in steel < 65 HRC | 0.06 mm |
| Shank $\varnothing D_s$ | 8 mm |
| Overall length L | 100 mm |
| Flute length L_c | 12 mm |
| Helix angle | 30 degrees |
| Radius R | 4 mm |
| Series | Diabolo |
| Coating | TiAlN |
| Tool material | Solid carbide |

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|---|----------------------------------|
| 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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