

Garant

Solid carbide slot drill HPC, TiAlN, Ø DC: 1,5mm



Order data

Order number	201648 1,5
GTIN	4045197641434
Item class	11X

Description

Version:

GARANT Diabolo 70:

Special solid carbide substrate with extremely high tensile strength combined with **outstanding wear resistance** for optimum process reliability. Newly developed **nano-crystalline high-tech coating for hard milling up to 70 HRC**. Very suitable for **continuous use** in tool and mould making.

Sizes 0.5 – 5: **Recess angle $\alpha = 15^\circ$** .

Application:

Due to the **special hard geometry** ideal for use on hardened materials from 60 HRC to 70 HRC.

Note:

f_z for $a_p = 0.05 \times D$.

Technical description

Feed f_z for side milling in steel < 70 HRC	0.005 mm
No. of teeth Z	2
Feed f_z for slot milling in steel < 70 HRC	0.004 mm
Cutting edge Ø D_c	1.5 mm
Shank Ø D_s	4 mm
Overall length L	40 mm
Flute length L_c	3.8 mm
Direction of infeed	horizontal, oblique and vertical
Shank	DIN 6535 HA to h6

Tolerance nominal \varnothing	0 / -0.02
Helix angle	35 degrees
Corner chamfer angle	90 degrees
Coating	TiAlN
Tool material	Solid carbide
Standard	Manufacturer's standard
Type	H
Helix angle characteristic	unequal spacing
Cutting width a_e for milling operation	0.05×D for side milling
Cutting width a_e for milling operation	Full slot cutting depth 1×D
Through-coolant	no
Machining strategy	HPC
Colour ring	red
Type of product	End / face mill

User data

	Suitability	V_c	ISO code
Steel < 60 HRC	suitable only under restricted conditions	60 m/min	H
Steel < 65 HRC	suitable	50 m/min	H
Steel < 67 HRC	suitable	40 m/min	H
Steel < 70 HRC	suitable	35 m/min	H
wet minimum	suitable only under restricted conditions		
dry	suitable		
Air	suitable		