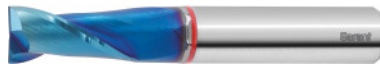


**Garant**
**GARANT Diabolo solid carbide slot drill HPC, TiAlN, Ø e8 DC: 1mm**

**Order data**

|              |               |
|--------------|---------------|
| Order number | 201639 1      |
| GTIN         | 4045197596925 |
| Item class   | 11X           |

**Description**
**Version:**
**GARANT Diabolo:**

Special geometry, coating and carbide specially for hard machining.

New generation of high performance milling cutters in the **HPC machining range**.

From size 2 with neck recess (dimensions  $L_1$  and  $\varnothing D_1$ ).

**Technical description**

|   |                                  |
|---|----------------------------------|
| No. of teeth Z                                | 2                                |
| Cutting edge $\varnothing D_c$                | 1 mm                             |
| Feed $f_z$ for side milling in steel < 65 HRC | 0.004 mm                         |
| Corner chamfer width at 45°                   | 0.02 mm                          |
| Feed $f_z$ for slot milling in steel < 65 HRC | 0.003 mm                         |
| Shank $\varnothing D_s$                       | 6 mm                             |
| Overall length L                              | 57 mm                            |
| Flute length $L_c$                            | 3 mm                             |
| Direction of infeed                           | horizontal, oblique and vertical |
| Shank   | DIN 6535 HA to h6                |
| Tolerance nominal $\varnothing$               | e8                               |
| Helix angle                                   | 30 degrees                       |
| Corner chamfer angle                          | 45 degrees                       |

|   |                             |
|---|-----------------------------|
| Series                                    | Diabolo                     |
| Coating                                   | TiAlN                       |
| Tool material                             | Solid carbide               |
| Standard                                  | DIN 6527                    |
| Type                                      | H                           |
| 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 < 1400 N/mm <sup>2</sup> | suitable                                  | 120 m/min | P        |
| Steel < 50 HRC                 | suitable                                  | 110 m/min | H        |
| Steel < 55 HRC                 | suitable                                  | 80 m/min  | H        |
| Steel < 60 HRC                 | suitable                                  | 60 m/min  | H        |
| Steel < 65 HRC                 | suitable                                  | 50 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 |
|------------------------|-----------|