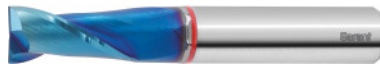


Garant
GARANT Diabolo solid carbide slot drill HPC, TiAlN, Ø e8 DC: 2,5mm

Order data

| | |
|--------------|---------------|
| Order number | 201639 2,5 |
| GTIN | 4045197596956 |
| 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 |
| Feed f_z for slot milling in steel < 65 HRC | 0.005 mm |
| Feed f_z for side milling in steel < 65 HRC | 0.007 mm |
| Cutting edge $\varnothing D_c$ | 2.5 mm |
| Overhang length L_1 incl. recess | 13 mm |
| Corner chamfer width at 45° | 0.04 mm |
| Recess $\varnothing D_1$ | 2.3 mm |
| Shank $\varnothing D_s$ | 6 mm |
| Overall length L | 57 mm |
| Flute length L_c | 6 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 ² | 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 |
|------------------------|-----------|

