

Garant
GARANT Diabolo solid carbide high-precision ball nose slot drill HPC, TiAlN, Ø DC: 4mm

Order data

Order number	207347 4
GTIN	4045197600004
Item class	11X

Description
Version:
GARANT Diabolo:

Special geometry, coating and carbide for hard machining.

Solid carbide high precision ball nose slot drill with radius Ø and contour variations within the µm range.

Tolerance: Radius contour = ± 0.005 mm.

Technical description

Feed f_z for copy milling in steel < 65 HRC	0.019 mm
Cutting edge Ø D_c	4 mm
Recess Ø D_1	3.8 mm
Feed f_z for side milling in steel < 65 HRC	0.019 mm
Overhang length L_1 incl. recess	9 mm
No. of teeth Z	2
Shank Ø D_s	4 mm
Overall length L	54 mm
Flute length L_c	4 mm
Helix angle	30 degrees
Radius R	2 mm

Series	Diabolo
Coating	TiAlN
Tool material	Solid carbide
Standard	Manufacturer's standard
Type	H
Tolerance nominal \varnothing	-0.007 / 0.002
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 h5
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		

