

Garant
GARANT Diabolo solid carbide ball nose slot drill HPC, TiAlN, Ø f8 DC: 1,5mm

Order data

| | |
|--------------|---------------|
| Order number | 207372 1,5 |
| GTIN | 4045197600349 |
| Item class | 11X |

Description
Version:
GARANT Diabolo:

Special geometry, coating and carbide for hard machining.

Taper transition with 1.5° (angle α).

Tolerance: Radius contour = ± 0.005 mm.

Technical description

| | |
|---|------------|
| No. of teeth Z | 2 |
| Recess $\varnothing D_1$ | 1.45 mm |
| Cutting edge $\varnothing D_c$ | 1.5 mm |
| $\varnothing D_2$ | 2.7 mm |
| L_2 | 27 mm |
| Feed f_z for copy milling in steel < 65 HRC | 0.005 mm |
| Overhang length L_1 incl. recess | 3 mm |
| Shank $\varnothing D_s$ | 3 mm |
| Overall length L | 75 mm |
| Flute length L_c | 1.8 mm |
| Helix angle | 30 degrees |
| Radius R | 0.75 mm |
| Series | Diabolo |

| | |
|---|----------------------------------|
| Coating | TiAlN |
| Tool material | Solid carbide |
| Standard | Manufacturer's standard |
| Type | H |
| Tolerance nominal \varnothing | f8 |
| Direction of infeed | horizontal, oblique and vertical |
| Cutting width a_e for milling operation | $0.05 \times D$ for copy 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 | 180 m/min | P |
| Steel < 50 HRC | suitable | 170 m/min | H |
| Steel < 55 HRC | suitable | 150 m/min | H |
| Steel < 60 HRC | suitable | 135 m/min | H |
| Steel < 65 HRC | suitable | 95 m/min | H |
| wet maximum | suitable only under restricted conditions | | |
| wet minimum | suitable only under restricted conditions | | |
| dry | suitable | | |
| Air | suitable | | |