

**Garant**
**GARANT Diabolo solid carbide high-precision ball nose slot drill HPC, TiAlN, Ø DC: 1,5mm**

**Order data**

Order number	207347 1,5
GTIN	4045197599964
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 =  $\pm 0.005$  mm.

**Technical description**

Feed $f_z$ for side milling in steel < 65 HRC	0.005 mm
Feed $f_z$ for copy milling in steel < 65 HRC	0.005 mm
Cutting edge Ø $D_c$	1.5 mm
Overhang length $L_1$ incl. recess	2.5 mm
No. of teeth Z	2
Recess Ø $D_1$	1.44 mm
Shank Ø $D_s$	3 mm
Overall length L	50 mm
Flute length $L_c$	1.5 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 $\varnothing$	-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 <sup>2</sup>	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		

