

**Garant**
**GARANT Diabolo solid carbide ball nose slot drill HPC, TiAlN, Ø f8 DC: 0,6mm**

**Order data**

Order number	207372 0,6
GTIN	4045197600301
Item class	11X

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

Special geometry, coating and carbide for hard machining.

Taper transition with 1.5° (angle  $\alpha$ ).

Tolerance: Radius contour =  $\pm 0.005$  mm.

**Technical description**

$L_2$	27 mm
No. of teeth Z	2
Cutting edge $\varnothing D_c$	0.6 mm
Feed $f_z$ for copy milling in steel < 65 HRC	0.005 mm
$\varnothing D_2$	1.9 mm
Overhang length $L_1$ incl. recess	1.4 mm
Recess $\varnothing D_1$	0.55 mm
Shank $\varnothing D_s$	3 mm
Overall length L	75 mm
Flute length $L_c$	0.8 mm
Helix angle	30 degrees
Radius R	0.3 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 <sup>2</sup>	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		