

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

**Order data**

Order number	207372 6
GTIN	4045197600394
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**

Ø D <sub>2</sub>	7.1 mm
Feed f <sub>z</sub> for copy milling in steel < 65 HRC	0.048 mm
L <sub>2</sub>	50 mm
Recess Ø D <sub>1</sub>	5.8 mm
Overhang length L <sub>1</sub> incl. recess	25 mm
Cutting edge Ø D <sub>c</sub>	6 mm
No. of teeth Z	2
Shank Ø D <sub>s</sub>	8 mm
Overall length L	100 mm
Flute length L <sub>c</sub>	6 mm
Helix angle	30 degrees
Radius R	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		

## Services

Shank grinding Type HB	129100 HB
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