

Garant
GARANT Diabolo solid carbide copy slot drill, TiAlN, Ø Dc × L1: 1,8X8mm

Order data

Order number	207373 1,8X8
GTIN	4045197936653
Item class	11X

Description
Version:
GARANT Diabolo:

Special geometry, coating and carbide **for hard machining in the high-performance field.**
Suitable even for **machining electrolytic copper.**

Recess angle $\alpha = 16^\circ$.

Tolerances:

- **Corner radius: Radius contour = 0 / -0.005 mm.**
- **Neck Ø: D₁ = 0 / -0.01 mm.**

Note:

At greater tool overhang lengths, use a reduced value for a_p!
values for:

copying: $a_p = 0.05 \times D \times a_{p, \text{corr}}$

To calculate the feed rate vf please use the actual speed of the machine (the maximum possible speed)! e.g: $vf = 18000 \text{ [rpm]} \times fz \text{ [mm/Z]} \times z$

Technical description

Feed f _z for copy milling in steel < 65 HRC	0.03 mm
No. of teeth Z	2
Shank Ø D _s	4 mm
Overhang length L ₁ incl. recess	8 mm
Recess Ø D ₁	1.74 mm
Helix angle	30 degrees
Correction factor a _{p, corr}	1

Flute length L_c	1.44 mm
Overall length L	45 mm
Corner radius R_1	0.9 mm
Cutting edge $\varnothing D_c$	1.8 mm
Series	Diabolo
Coating	TiAlN
Tool material	Solid carbide
Standard	Manufacturer's standard
Type	H
Tolerance nominal \varnothing	0 / -0,005
Direction of infeed	horizontal, oblique and vertical
Cutting width a_e for milling operation	0.05×D for copy milling
Shank	DIN 6535 HA to h5
Through-coolant	no
Colour ring	red
Type of product	Ball-nosed slot drill

User data

	Suitability	V_c	ISO code
Steel < 750 N/mm ²	suitable only under restricted conditions	200 m/min	P
Steel < 900 N/mm ²	suitable only under restricted conditions	200 m/min	P
Steel < 1100 N/mm ²	suitable	190 m/min	P
Steel < 1400 N/mm ²	suitable	170 m/min	P
Steel < 50 HRC	suitable	120 m/min	H
Steel < 55 HRC	suitable	100 m/min	H
Steel < 60 HRC	suitable	72 m/min	H
Steel < 65 HRC	suitable	55 m/min	H

Steel < 67 HRC	suitable	50 m/min	H
Steel < 70 HRC	suitable	45 m/min	H
INOX < 900 N/mm ²	suitable	90 m/min	M
INOX > 900 N/mm ²	suitable	80 m/min	M
CuZn	suitable	140 m/min	N
wet maximum	suitable only under restricted conditions		
wet minimum	suitable only under restricted conditions		
dry	suitable		
Air	suitable		