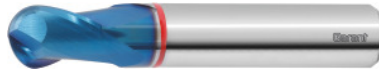


**Garant**
**GARANT Diabolo solid carbide ball nose slot drill HPC, TiAlN, Ø f8 DC / DS:  
1mm**

**Order data**

|              |               |
|--------------|---------------|
| Order number | 207342 1      |
| GTIN         | 4045197599629 |
| Item class   | 11X           |

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

Special geometry, coating and carbide for hard machining.

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

**Technical description**

|   |               |
|---|---------------|
| No. of teeth Z                                | 2             |
| Feed $f_z$ for copy milling in steel < 65 HRC | 0.005 mm      |
| Feed $f_z$ for side milling in steel < 65 HRC | 0.005 mm      |
| Cutting edge $\varnothing D_c$                | 1 mm          |
| Shank $\varnothing D_s$                       | 3 mm          |
| Overall length L                              | 50 mm         |
| Flute length $L_c$                            | 2 mm          |
| Helix angle                                   | 30 degrees    |
| Radius R                                      | 0.5 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 | 0.2×D for side milling           |
| Cutting width $a_e$ for milling operation | 0.05×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                                  | 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                                  |           |          |