

Garant
GARANT Diabolo solid carbide slot drill HPC, TiAlN, Ø e8 DC: 4mm

Order data

Order number	201639 4
GTIN	4045197596987
Item class	11X

Description
Version:
GARANT Diabolo:

Special geometry, coating and carbide specially for hard machining.

New generation of high performance milling cutters in the **HPC machining range**.

From size 2 with neck recess (dimensions L_1 and $\varnothing D_1$).

Technical description

Cutting edge $\varnothing D_c$	4 mm
Recess $\varnothing D_1$	3.8 mm
No. of teeth Z	2
Feed f_z for slot milling in steel < 65 HRC	0.008 mm
Overhang length L_1 incl. recess	15 mm
Feed f_z for side milling in steel < 65 HRC	0.01 mm
Corner chamfer width at 45°	0.05 mm
Shank $\varnothing D_s$	6 mm
Overall length L	57 mm
Flute length L_c	11 mm
Direction of infeed	horizontal, oblique and vertical
Shank	DIN 6535 HA to h6
Tolerance nominal \varnothing	e8

Helix angle	30 degrees
Corner chamfer angle	45 degrees
Series	Diabolo
Coating	TiAlN
Tool material	Solid carbide
Standard	DIN 6527
Type	H
Cutting width a_e for milling operation	0.05×D for side milling
Cutting width a_e for milling operation	Full slot cutting depth 1×D
Through-coolant	no
Machining strategy	HPC
Colour ring	red
Type of product	End / face mill

User data

	Suitability	V_c	ISO code
Steel < 1400 N/mm ²	suitable	120 m/min	P
Steel < 50 HRC	suitable	110 m/min	H
Steel < 55 HRC	suitable	80 m/min	H
Steel < 60 HRC	suitable	60 m/min	H
Steel < 65 HRC	suitable	50 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
------------------------	-----------

