

Garant
GARANT Diabolo solid carbide ball nose slot drill HPC, TiAlN, Ø f8 DC: 8mm

Order data

Order number	207372 8
GTIN	4045197600400
Item class	11X

Description
Version:
GARANT Diabolo:

Special geometry, coating and carbide for hard machining.

Taper transition with 1.5° (angle α).

Tolerance: Radius contour = ± 0.005 mm.

Technical description

Ø D ₂	9.3 mm
Recess Ø D ₁	7.8 mm
Feed f _z for copy milling in steel < 65 HRC	0.06 mm
Cutting edge Ø D _c	8 mm
No. of teeth Z	2
Overhang length L ₁ incl. recess	32 mm
L ₂	60 mm
Shank Ø D _s	10 mm
Overall length L	120 mm
Flute length L _c	7 mm
Helix angle	30 degrees
Radius R	4 mm
Series	Diabolo

Coating	TiAlN
Tool material	Solid carbide
Standard	Manufacturer's standard
Type	H
Tolerance nominal Ø	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 ²	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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