

Garant
Solid carbide copy slot drill, Diamond, Ø DC × L1: 0,3X1mm

Order data

Order number	209791 0,3X1
GTIN	4045197919731
Item class	10Y

Description
Version:

With **crystalline diamond sp³ coating**. For the **highest demands regarding performance and precision** in fibre-reinforced composites, CRP, GRP, and graphite. **Extremely tight tolerances** ensure maximum accuracy. Double relief ground with 2 hollow-ground chamfers. **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 = 0.15 × D × a_{p korr}

To calculate the feed rate vf please use the actual speed of the machine (the maximum possible speed)!

e.g: vf = 18000 [rpm] × fz [mm/Z] × z

Technical description

Recess Ø D ₁	0.27 mm
Feed f _z for copy milling in graphite	0.016 mm
Overhang length L ₁ incl. recess	1 mm
Shank Ø D _s	4 mm
Cutting edge Ø D _c	0.3 mm
No. of teeth Z	2

Flute length L_c	0.24 mm
Overall length L	45 mm
Corner radius R_1	0.15 mm
Helix angle	25 degrees
Correction factor $a_{p\text{corr}}$	1
Coating	Diamond
Tool material	Solid carbide
Standard	Manufacturer's standard
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	black
Type of product	Ball-nosed slot drill

User data

	Suitability	V_c	ISO code
PVDF GF20	suitable	200 m/min	N
POM GF25	suitable	190 m/min	N
PA 66 GF30	suitable	170 m/min	N
PEEK GF30	suitable	150 m/min	N
PTFE CF25	suitable	180 m/min	N
PEEK CF30	suitable	160 m/min	N
Hybrids	suitable		
Honeycomb sandwich	suitable	350 m/min	N
GRP	suitable	190 m/min	N
GRP, CRP	suitable	190 m/min	N
Graphite	suitable	340 m/min	N

wet minimum	suitable
dry	suitable
Air	suitable