

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

Order number	207372 1
GTIN	4045197600325
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

Overhang length L_1 incl. recess	2 mm
$\varnothing D_2$	2.3 mm
Feed f_z for copy milling in steel < 65 HRC	0.005 mm
Recess $\varnothing D_1$	0.95 mm
L_2	27 mm
Cutting edge $\varnothing D_c$	1 mm
No. of teeth Z	2
Shank $\varnothing D_s$	3 mm
Overall length L	75 mm
Flute length L_c	1.2 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 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		