

Garant**Solid carbide ball nose slot drill, Diamond, Ø f8 DC / DS: 1,5/6mm****Order data**

Order number	209781 1,5/6
GTIN	4045197544315
Item class	10Y

Description**Version:**

With the latest generation of **crystalline diamond coating sp³**, for process reliability in machining **fibre-reinforced composites, CRP, GRP and graphite**. Double relief ground side clearance angle.

Tolerance: Radius contour = **±0.01 mm**.

Technical description

Recess Ø D ₁	1.44 mm
Overhang length L ₁ incl. recess	22 mm
Feed f _z for side milling in graphite	0.011 mm
Feed f _z for copy milling in graphite	0.011 mm
Cutting edge Ø D _c	1.5 mm
No. of teeth Z	2
Shank Ø D _s	6 mm
Overall length L	80 mm
Flute length L _c	3 mm
Helix angle	30 degrees
Radius R	0.75 mm
Coating	Diamond
Tool material	Solid carbide

Standard	Manufacturer's standard
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
Cutting width a_e for milling operation	$0.2 \times D$ for side milling
Shank	DIN 6535 HA with h6
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		

Services

Shank grinding Type HB	129100 HB
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