

**Garant**
**Diabolo solid carbide ball nose slot drill HPC, TiAlN, Ø f8 DC: 0,8mm**

**Order data**

Order number	207372 0,8
GTIN	4045197600318
Item class	11X

**Description**
**Version:**
**GARANT Diabolo:**

Special geometry, coating and carbide for hard machining.

Taper transition with 1.5° (angle  $\alpha$ ).

Tolerance: Radius contour =  $\pm 0.005$  mm.

No. of teeth Z: 2

Helix angle: 30°

No. of teeth Z: 2

Flute length  $L_c$ : 1 mm

Overhang length  $L_1$  incl. recess: 1.6 mm

Recess Ø  $D_1$ : 0.75 mm

Overall length L: 75 mm

Shank Ø  $D_s$ : 3 mm

**Technical description**

Recess Ø $D_1$	0.75 mm
$L_2$	27 mm
Cutting edge Ø $D_c$	0.8 mm
Ø $D_2$	2.1 mm
Overhang length $L_1$ incl. recess	1.6 mm
No. of teeth Z	2
Feed $f_z$ for copy milling in steel < 65 HRC	0.005 mm
Shank Ø $D_s$	3 mm

Overall length L	75 mm
Flute length L <sub>c</sub>	1 mm
Helix angle	30°
Radius R	0.4 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 <sub>e</sub> for milling operation	0.05×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 <sub>c</sub>	ISO code
Steel < 1400 N/mm <sup>2</sup>	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