

Garant
Diabolo solid carbide copy slot drill, TiAlN, Ø Dc × L1: 0,2X0,5mm


Order data

Order number	207377 0,2X0,5
GTIN	4062406387556
Item class	11X

Description

Version:

GARANT Diabolo:

Special geometry, coating and carbide **for hard machining in the high-performance field.**

Suitable even for **machining electrolytic copper.**

Recess angle $\alpha = 16^\circ$.

Extra-sturdy shank for achieving longer tool life.

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: $a_p = 0.05 \times D \times a_{p, \text{korr}}$

To calculate the feed rate vf please use the actual speed of the machine (the maximum possible speed)! e.g: $vf = 18000 \text{ [rpm]} \times fz \text{ [mm/Z]} \times z$

No. of teeth Z: 2

Helix angle: 25 °

No. of teeth Z: 2

Flute length L_c: 0.16 mm

Corner radius R₁: 0.1 mm

Overhang length L₁ incl. recess: 0.5 mm

Recess Ø D₁: 0.17 mm

Overall length L: 54 mm

Technical description

Overall length L	54 mm
Corner radius R ₁	0.1 mm
Correction factor a _{p corr}	1
Cutting edge Ø D _c	0.2 mm
Helix angle	25 °
Shank Ø D _s	6 mm
Overhang length L ₁ incl. recess	0.5 mm
No. of teeth Z	2
Flute length L _c	0.16 mm
Feed f _z for copy milling in steel < 65 HRC	0.01 mm
Recess Ø D ₁	0.17 mm
Series	Diabolo
Coating	TiAlN
Tool material	Solid carbide
Standard	Manufacturer's standard
Type	H
Tolerance nominal Ø	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	red
Type of product	Ball-nosed slot drill

User data

	Suitability	V _c	ISO code
Steel < 750 N/mm ²	suitable only under restricted conditions	200 m/min	P

Steel < 900 N/mm ²	suitable only under restricted conditions	200 m/min	P
Steel < 1100 N/mm ²	suitable	190 m/min	P
Steel < 1400 N/mm ²	suitable	170 m/min	P
Steel < 50 HRC	suitable	120 m/min	H
Steel < 55 HRC	suitable	100 m/min	H
Steel < 60 HRC	suitable	72 m/min	H
Steel < 65 HRC	suitable	55 m/min	H
Steel < 67 HRC	suitable	50 m/min	H
Steel < 70 HRC	suitable	45 m/min	H
INOX < 900 N/mm ²	suitable	90 m/min	M
INOX > 900 N/mm ²	suitable	80 m/min	M
CuZn	suitable	140 m/min	N
wet maximum	suitable only under restricted conditions		
wet minimum	suitable only under restricted conditions		
dry	suitable		
Air	suitable		