

Garant
Diabolo solid carbide ball nose slot drill HPC, TiAlN, Ø f8 DC / DS: 12mm

Order data

Order number	207476 12
GTIN	4045197600776
Item class	11X

Description
Version:
GARANT Diabolo:

Special geometry, newly developed coating and carbide for hard machining. 4 centre cutting edges to the centre. Therefore can be used as a true **4-edge drill** at all depths of cut.

Tolerance: Radius contour = ± 0.005 mm.

No. of teeth Z: 4

Helix angle: 30 °

No. of teeth Z: 4

Flute length L_c : 16 mm

Overall length L: 100 mm

Shank Ø D_s : 12 mm

Feed f_z for side milling in steel < 65 HRC: 0.08 mm

Feed f_z for copy milling in steel < 65 HRC: 0.08 mm

Technical description

No. of teeth Z	4
Feed f_z for copy milling in steel < 65 HRC	0.08 mm
Cutting edge Ø D_c	12 mm
Feed f_z for side milling in steel < 65 HRC	0.08 mm
Shank Ø D_s	12 mm
Overall length L	100 mm
Flute length L_c	16 mm
Helix angle	30 °

Radius R	6 mm
Series	Diabolo
Coating	TiAlN
Tool material	Solid carbide
Standard	Manufacturer's standard
Type	H
Tolerance nominal \varnothing	f8
Direction of infeed	horizontal, oblique and vertical
Cutting width a_e for milling operation	0.05×D for copy milling
Cutting width a_e for milling operation	0.2×D for side 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	200 m/min	P
Steel < 50 HRC	suitable	190 m/min	H
Steel < 55 HRC	suitable	170 m/min	H
Steel < 60 HRC	suitable	150 m/min	H
Steel < 65 HRC	suitable	110 m/min	H
wet maximum	suitable only under restricted conditions		
wet minimum	suitable only under restricted conditions		
dry	suitable		
Air	suitable		

Services

Shank recess Type FRST	209900 FRST
Shank clamping flats for shrink-fit chucks, with retainer function Shank Ø tool 12 mm	SZ2025 12
Shank grinding Type HB	129100 HB