

Garant
Diabolo solid carbide high precision ball nose slot drill HPC, TiAlN, Ø DC: 2mm

Order data

Order number	207347 2
GTIN	4045197599971
Item class	11X

Description
Version:
GARANT Diabolo:

Special geometry, coating and carbide for hard machining.

Solid carbide high precision ball nose slot drill with radius Ø and contour variations within the µm range.

Tolerance: Radius contour = ± 0.005 mm.

No. of teeth Z: 2

Helix angle: 30 °

No. of teeth Z: 2

Flute length L_c : 2 mm

Overhang length L_1 incl. recess: 4 mm

Recess Ø D_1 : 1.92 mm

Overall length L: 50 mm

Shank Ø D_s : 3 mm

Technical description

Cutting edge Ø D_c	2 mm
Feed f_z for side milling in steel < 65 HRC	0.005 mm
No. of teeth Z	2
Recess Ø D_1	1.92 mm
Overhang length L_1 incl. recess	4 mm
Feed f_z for copy milling in steel < 65 HRC	0.005 mm

Shank $\varnothing D_s$	3 mm
Overall length L	50 mm
Flute length L_c	2 mm
Helix angle	30 °
Radius R	1 mm
Series	Diabolo
Coating	TiAlN
Tool material	Solid carbide
Standard	Manufacturer's standard
Type	H
Tolerance nominal \varnothing	-0.007 / 0.002
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 h5
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