


Solid carbide ball nose slot drill, TiAlN, Ø h10 DC: 4mm

Order data

Order number	207154 4
GTIN	4062406264888
Item class	12X

Description
Note:

Successor product to No. 207155.

Technical description

Feed f_z for side milling in steel < 900 N/mm ²	0.023 mm
Helix angle	30 degrees
Shank Ø D_s	4 mm
No. of teeth Z	2
Cutting edge Ø D_c	4 mm
Flute length L_c	8 mm
Feed f_z for copy milling in steel < 900 N/mm ²	0.025 mm
Overall length L	75 mm
Radius R	2 mm
Coating	TiAlN
Tool material	Solid carbide
Standard	Manufacturer's standard
Type	N
Tolerance nominal Ø	h10
Direction of infeed	horizontal, oblique and vertical

Cutting width a_e for milling operation	Full slot cutting depth $1 \times D$
Cutting width a_e for milling operation	$0.05 \times D$ for copy milling
Shank	DIN 6535 HA to h6
Through-coolant	no
Colour ring	without
Type of product	Ball-nosed slot drill

User data

	Suitability	V_c	ISO code
Aluminium (short chipping)	suitable only under restricted conditions	350 m/min	N
Alu > 10% Si	suitable only under restricted conditions	250 m/min	N
Steel < 500 N/mm ²	suitable only under restricted conditions	160 m/min	P
Steel < 750 N/mm ²	suitable only under restricted conditions	140 m/min	P
Steel < 900 N/mm ²	suitable	130 m/min	P
Steel < 1100 N/mm ²	suitable	80 m/min	P
Steel < 1400 N/mm ²	suitable only under restricted conditions	70 m/min	P
Steel < 55 HRC	suitable only under restricted conditions	50 m/min	H
INOX < 900 N/mm ²	suitable	80 m/min	M
INOX > 900 N/mm ²	suitable only under restricted conditions	70 m/min	M
GG(G)	suitable	120 m/min	K
CuZn	suitable only under restricted conditions	320 m/min	N
Uni	suitable		
wet maximum	suitable		

wet minimum	suitable only under restricted conditions
dry	suitable only under restricted conditions
Air	Suitable only under restricted conditions