


**Solid carbide ball nose slot drill, TiAlN, Ø h10 DC: 6mm**

**Order data**

Order number	207154 6
GTIN	4062406264901
Item class	12X

**Description**
**Note:**

Successor product to No. 207155.

**Technical description**

Cutting edge Ø D <sub>c</sub>	6 mm
Feed f <sub>z</sub> for side milling in steel < 900 N/mm <sup>2</sup>	0.033 mm
Flute length L <sub>c</sub>	10 mm
Shank Ø D <sub>s</sub>	6 mm
Helix angle	30 degrees
Feed f <sub>z</sub> for copy milling in steel < 900 N/mm <sup>2</sup>	0.037 mm
No. of teeth Z	2
Overall length L	100 mm
Radius R	3 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 <sup>2</sup>	suitable only under restricted conditions	160 m/min	P
Steel < 750 N/mm <sup>2</sup>	suitable only under restricted conditions	140 m/min	P
Steel < 900 N/mm <sup>2</sup>	suitable	130 m/min	P
Steel < 1100 N/mm <sup>2</sup>	suitable	80 m/min	P
Steel < 1400 N/mm <sup>2</sup>	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 <sup>2</sup>	suitable	80 m/min	M
INOX > 900 N/mm <sup>2</sup>	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
<b>Services</b>	
Shank grinding Type HB	129100 HB