


Solid carbide ball nose slot drill, TiAlN, Ø h10 DC: 8mm

Order data

Order number	207154 8
GTIN	4062406264703
Item class	12X

Description
Note:

Successor product to No. 207155.

Technical description

Helix angle	30 degrees
No. of teeth Z	2
Flute length L_c	12 mm
Feed f_z for copy milling in steel < 900 N/mm ²	0.051 mm
Feed f_z for side milling in steel < 900 N/mm ²	0.045 mm
Overall length L	100 mm
Cutting edge Ø D_c	8 mm
Shank Ø D_s	8 mm
Radius R	4 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
Services	
Shank grinding Type HB	129100 HB