

**Garant**
**GARANT Master Steel solid carbide ball nose slot drill HPC, TiAlN, Ø f8 DC / D S: 1mm**

**Order data**

Order number	207242 1
GTIN	4062406284817
Item class	11X

**Description**
**Version:**

**Precision ground for very high accuracy requirements.**

Tolerance: Radius contour =  $\pm 0.005$  mm.

Improved cutting edge protection thanks to slight edge honing. Tremendous bending strength due to the use of ultra-fine grain substrate.

**Technical description**

Cutting edge $\varnothing D_c$	1 mm
Feed $f_z$ for copy milling in steel $< 900$ N/mm <sup>2</sup>	0.015 mm
No. of teeth Z	2
Overall length L	50 mm
Flute length $L_c$	2.5 mm
Shank $\varnothing D_s$	3 mm
Helix angle	28 degrees
Feed $f_z$ for side milling in steel $< 900$ N/mm <sup>2</sup>	0.012 mm
Radius R	0.5 mm
Series	Master Steel
Coating	TiAlN
Tool material	Solid carbide

Standard	Manufacturer's standard
Type	N
Tolerance nominal $\varnothing$	f8
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	$0.03 \times D$ for copy milling
Shank	DIN 6535 HA to h6
Through-coolant	no
Machining strategy	HPC
Colour ring	green
Type of product	Ball-nosed slot drill

## User data

	Suitability	$V_c$	ISO code
Steel < 500 N/mm <sup>2</sup>	Suitable	270 m/min	P
Steel < 750 N/mm <sup>2</sup>	Suitable	240 m/min	P
Steel < 900 N/mm <sup>2</sup>	suitable	220 m/min	P
Steel < 1100 N/mm <sup>2</sup>	suitable	190 m/min	P
Steel < 1400 N/mm <sup>2</sup>	suitable	170 m/min	P
Steel < 55 HRC	suitable only under restricted conditions	140 m/min	H
INOX < 900 N/mm <sup>2</sup>	suitable	90 m/min	M
INOX > 900 N/mm <sup>2</sup>	suitable only under restricted conditions	80 m/min	M
GG(G)	suitable only under restricted conditions	400 m/min	K
Uni	Suitable		
wet maximum	Suitable		
wet minimum	suitable only under restricted conditions		

dry	suitable
Air	Suitable