

Garant
**GARANT Master Steel solid carbide ball nose slot drill HPC, TiAlN, Ø f8 DC / D
S: 6mm**

Order data

| | |
|--------------|---------------|
| Order number | 207244 6 |
| GTIN | 4062406285197 |
| Item class | 11X |

Description
Version:

Precision ground for very high accuracy requirements.

Tolerance: Radius contour = ± 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

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| Feed f_z for copy milling in steel < 900 N/mm ² | 0.08 mm |
| No. of teeth Z | 2 |
| Cutting edge $\varnothing D_c$ | 6 mm |
| Overall length L | 100 mm |
| Helix angle | 28 degrees |
| Shank $\varnothing D_s$ | 6 mm |
| Flute length L_c | 10 mm |
| Feed f_z for side milling in steel < 900 N/mm ² | 0.06 mm |
| Radius R | 3 mm |
| Series | Master Steel |
| Coating | TiAlN |
| Tool material | Solid carbide |

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|---|----------------------------------|
| Standard | Manufacturer's standard |
| Type | N |
| Tolerance nominal \varnothing | f8 |
| Direction of infeed | horizontal, oblique and vertical |
| Cutting width a_e for milling operation | 0.5×D for side milling |
| Cutting width a_e for milling operation | 0.03×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 ² | Suitable | 260 m/min | P |
| Steel < 750 N/mm ² | Suitable | 230 m/min | P |
| Steel < 900 N/mm ² | suitable | 210 m/min | P |
| Steel < 1100 N/mm ² | suitable | 180 m/min | P |
| Steel < 1400 N/mm ² | suitable | 160 m/min | P |
| Steel < 55 HRC | suitable only under restricted conditions | 130 m/min | H |
| INOX < 900 N/mm ² | suitable | 85 m/min | M |
| INOX > 900 N/mm ² | suitable only under restricted conditions | 75 m/min | M |
| GG(G) | suitable only under restricted conditions | 350 m/min | K |
| Uni | Suitable | | |
| wet maximum | suitable | | |
| wet minimum | suitable only under restricted conditions | | |

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|-----|----------|
| dry | Suitable |
| Air | Suitable |