Garant

GARANT Master Steel solid carbide ball nose slot drill HPC, TiAlN, ∅ f8 DC: 12mm

Order data

Order number	207490 12
GTIN	4062406285388
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

Flute length L_c	16 mm
Shank ∅ D_s	12 mm
Overhang length L_1 incl. recess	38 mm
Helix angle	30 degrees
Feed f_z for side milling in steel < 900 N/mm^2	0.07 mm
Recess ∅ D_1	11.5 mm
Overall length L	83 mm
No. of teeth Z	4
Cutting edge ∅ D_C	12 mm
Feed f_z for copy milling in steel < 900 N/mm^2	0.075 mm
Radius R	6 mm
Series	Master Steel

Coating	TiAlN
Tool material	Solid carbide
Standard	Manufacturer's standard
Type	N
Tolerance nominal ∅	f8
Direction of infeed	horizontal, oblique and vertical
Cutting width a_e for milling operation	0.03×D for copy milling
Cutting width a_e for milling operation	Full slot cutting depth 1×D
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/mm²	Suitable	270 m/min	P
Steel < 750 N/mm²	Suitable	240 m/min	P
Steel < 900 N/mm²	suitable	220 m/min	P
Steel < 1100 N/mm²	suitable	190 m/min	P
Steel < 1400 N/mm²	Suitable	170 m/min	P
Steel < 55 HRC	suitable only under restricted conditions	140 m/min	H
INOX < 900 N/mm²	suitable	90 m/min	M
INOX > 900 N/mm²	suitable only under restricted conditions	80 m/min	M
GG(G)	Suitable	400 m/min	K
Uni	Suitable		
wet maximum	Suitable		

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