

Garant
Solid carbide ball nose slot drill MTC, TiAlN, Ø f8 DC: 4mm

Order data

Order number	207450 4
GTIN	4045197128669
Item class	11X

Description
Version:

Ball nose slot drills with corrected cutting form, without profile distortion. With double relief ground side clearance angle.

Tolerance: Radius contour = ± 0.005 mm.

Application:

Especially for **MTC (Multi Task Cutting)** use on the new generation of turning / milling centres.

Note:

NEW GENERATION AVAILABLE! Recommended successor product is No. 207490.

Technical description

Feed f_z for side milling in steel < 900 N/mm ²	0.03 mm
Feed f_z for copy milling in steel < 900 N/mm ²	0.037 mm
No. of teeth Z	4
Cutting edge Ø D_c	4 mm
Shank Ø D_s	4 mm
Overall length L	54 mm
Flute length L_c	8 mm
Helix angle	45 degrees
Radius R	2 mm
Coating	TiAlN

Tool material	Solid carbide
Standard	DIN 6527
Type	N
Tolerance nominal \varnothing	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	0.3×D for side milling
Shank	DIN 6535 HA to h6
Through-coolant	no
Machining strategy	MTC
Colour ring	without
Type of product	Ball-nosed slot drill

User data

	Suitability	V_c	ISO code
Steel < 500 N/mm ²	suitable	225 m/min	P
Steel < 750 N/mm ²	suitable	210 m/min	P
Steel < 900 N/mm ²	suitable	180 m/min	P
Steel < 1100 N/mm ²	suitable	145 m/min	P
Steel < 1400 N/mm ²	suitable	140 m/min	P
INOX < 900 N/mm ²	suitable	85 m/min	M
GG(G)	suitable	350 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		

