

**Garant**
**Solid carbide ball nose slot drill, DLC, Ø f8 DC: 20mm**

**Order data**

Order number	207441 20
GTIN	4045197591111
Item class	11X

**Description**
**Version:**

With the latest generation of **DLC coating sp<sup>2</sup>**. For **high-performance milling of aluminium materials**. 4 centre cutting edges to the centre. Therefore can be used as a true **4-edge drill** at all depths of cut.

Tolerance: Radius contour = **±0.005 mm**.

**Technical description**

No. of teeth Z	4
Feed $f_z$ for copy milling in cast aluminium	0.2 mm
Recess Ø $D_1$	19 mm
Cutting edge Ø $D_c$	20 mm
Overhang length $L_1$ incl. recess	50 mm
Shank Ø $D_s$	20 mm
Overall length L	93 mm
Flute length $L_c$	25 mm
Helix angle	45 degrees
Radius R	10 mm
Coating	DLC
Tool material	Solid carbide

Standard	Manufacturer's standard
Type	W
Tolerance nominal $\varnothing$	f8
Direction of infeed	horizontal, oblique and vertical
Cutting width $a_e$ for milling operation	$0.1 \times D$ for copy milling
Shank	DIN 6535 HA to h6
Through-coolant	no
Colour ring	yellow
Type of product	Ball-nosed slot drill

## User data

	Suitability	$V_c$	ISO code
Aluminium	Suitable	600 m/min	N
Aluminium (short chipping)	suitable	550 m/min	N
Alu > 10% Si	suitable	500 m/min	N
PMMA acrylic	Suitable	220 m/min	N
PE-HD	Suitable	180 m/min	N
PA 66	Suitable	220 m/min	N
PEEK	Suitable	170 m/min	N
PF 31	Suitable	150 m/min	N
PVDF GF20	Suitable	200 m/min	N
POM GF25	Suitable	180 m/min	N
PA 66 GF30	Suitable	170 m/min	N
PEEK GF30	Suitable	140 m/min	N
PTFE CF25	Suitable	180 m/min	N
Honeycomb sandwich	suitable only under restricted conditions	320 m/min	N
Cu	Suitable	180 m/min	N

CuZn	Suitable	220 m/min	N
wet maximum	suitable		
wet minimum	Suitable		
dry	suitable only under restricted conditions		
Air	Suitable		

**Services**

Shank grinding Type HB	129100 HB
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