

Garant
Solid carbide ball nose slot drill MTC, TiAlN, Ø f8 DC: 20mm

Order data

Order number	207450 20
GTIN	4045197128744
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	0.112 mm
Feed f_z for copy milling in steel < 900 N/mm ²	0.138 mm
Cutting edge $\varnothing D_c$	20 mm
No. of teeth Z	4
Shank $\varnothing D_s$	20 mm
Overall length L	92 mm
Flute length L_c	26 mm
Helix angle	45 degrees
Radius R	10 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		

Services

Shank grinding Type HB

129100 HB