

Garant
Solid carbide ball nose slot drill HPC, TiAlN, Ø f8 DC / DS: 5/6mm

Order data

Order number	207478 5/6
GTIN	4045197455567
Item class	11X

Description
Version:

Special geometry and **coating** for machining **stainless and acid-resistant steels**. 4 end faces up to the centre. Therefore can be used as a true **4-edge drill** at all depths of cut.

Tolerance: Radius contour = ± 0.005 mm.

Note:

New generation available! Successor product is No. 207474.

Technical description

No. of teeth Z	4
Feed f_z for side milling in INOX < 900 N/mm ²	0.012 mm
Cutting edge Ø D _c	5 mm
Feed f_z for copy milling in stainless steel < 900 N/mm ²	0.013 mm
Shank Ø D _s	6 mm
Overall length L	80 mm
Flute length L _c	9 mm
Correction factor for v _c	1.25
Helix angle	45 degrees
Radius R	2.5 mm
Coating	TiAlN
Tool material	Solid carbide

Standard	Manufacturer's standard
Type	N
Tolerance nominal \varnothing	f8
Direction of infeed	horizontal, oblique and vertical
Cutting width a_e for milling operation	0.05×D for copy milling
Cutting width a_e for milling operation	0.5×D for side milling
Shank	DIN 6535 HA to h6
Through-coolant	no
Machining strategy	HPC
Colour ring	blue
Type of product	Ball-nosed slot drill

User data

	Suitability	V_c	ISO code
Steel < 500 N/mm ²	suitable	250 m/min	P
Steel < 750 N/mm ²	suitable	230 m/min	P
Steel < 900 N/mm ²	suitable	200 m/min	P
Steel < 1100 N/mm ²	suitable	160 m/min	P
INOX < 900 N/mm ²	suitable	95 m/min	M
INOX > 900 N/mm ²	suitable	85 m/min	M
wet maximum	suitable		
wet minimum	suitable		

Services

Shank grinding Type HB	129100 HB
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