Garant

Solid carbide ball nose milling cutter HPC, TiAlN, ⌀ f8 DC / DS: 4/6mm

Order data

Order number	207485 4/6
GTIN	4045197354426
Item class	11X

Description

Version:
Special geometry for machining **titanium and titanium alloys**. 4 end face edges up to the centre. Thus can be used as a **true 4-flute slot drill** at all depths of cut.
Tolerance: Radius contour = **±0.005 mm.**
Note:
NEW GENERATION AVAILABLE! Recommended successor product is No. 207487.

Technical description

No. of teeth Z	4
Cutting edge ⌀ D_C	4 mm
Feed f_z for copy milling in titanium > 850 N/mm^2	0.02 mm
Feed f_z for side milling in titanium > 850 N/mm^2	0.016 mm
Shank ⌀ D_s	6 mm
Overall length L	80 mm
Flute length L_c	8 mm
Correction factor for v_c	1.25
Helix angle	45 degrees
Radius R	2 mm
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	0.05×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	pink
Type of product	Ball-nosed slot drill

User data

	Suitability	V_c	ISO code
Ti > 850 N/mm²	suitable	50 m/min	S
Inconel	suitable	30 m/min	S
wet maximum	suitable		

Services

Shank grinding Type HB	129100 HB