Garant

Solid carbide ball nose milling cutter HPC, TiAlN, ∅ f8 DC / DS: 3/6mm

Order data

Order number	207478 3/6
GTIN	4045197455543
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

Cutting edge ∅ D_C	3 mm
Feed f_z for copy milling in stainless steel < 900 N/mm^2	0.007 mm
Feed f_z for side milling in INOX < 900 N/mm^2	0.006 mm
No. of teeth Z	4
Shank ∅ D_s	6 mm
Overall length L	80 mm
Flute length L_c	5 mm
Correction factor for v_c	1.25
Helix angle	45 degrees
Radius R	1.5 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	blue
Type of product	Ball-nosed slot drill

User data

	Suitability	V_c	ISO code
Steel < 500 N/mm²	suitable	250 m/min	P
Steel < 750 N/mm²	suitable	230 m/min	P
Steel < 900 N/mm²	suitable	200 m/min	P
Steel < 1100 N/mm²	suitable	160 m/min	P
INOX < 900 N/mm²	suitable	95 m/min	M
INOX > 900 N/mm²	suitable	85 m/min	M
wet maximum	suitable		
wet minimum	suitable		

Services

Shank grinding Type HB	129100 HB