

Garant
Solid carbide ball nose slot drill HPC, TiAlN, Ø f8 DC / DS: 8mm

Order data

| | |
|--------------|---------------|
| Order number | 207485 8 |
| GTIN | 4045197354457 |
| 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

| | |
|---|---------------|
| Feed f_z for copy milling in titanium > 850 N/mm ² | 0.039 mm |
| Cutting edge $\varnothing D_c$ | 8 mm |
| Feed f_z for side milling in titanium > 850 N/mm ² | 0.032 mm |
| No. of teeth Z | 4 |
| Shank $\varnothing D_s$ | 8 mm |
| Overall length L | 100 mm |
| Flute length L_c | 12 mm |
| Correction factor for v_c | 1.25 |
| Helix angle | 45 degrees |
| Radius R | 4 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 | pink |
| Type of product | Ball-nosed slot drill |

User data

| | Suitability | V_c | ISO code |
|----------------------------|-------------|----------|----------|
| Ti > 850 N/mm ² | suitable | 50 m/min | S |
| Inconel | suitable | 30 m/min | S |
| wet maximum | suitable | | |

Services

| | |
|------------------------|-----------|
| Shank grinding Type HB | 129100 HB |
|------------------------|-----------|