

**Garant**
**Solid carbide ball nose slot drill HPC, TiAlN, Ø f8 DC / DS: 4/6mm**

**Order data**

Order number	207478 4/6
GTIN	4045197455550
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 =  $\pm 0.005$  mm.

**Note:**

**New generation available!** Successor product is No. 207474.

**Technical description**

No. of teeth Z	4
Cutting edge Ø D <sub>c</sub>	4 mm
Feed f <sub>z</sub> for side milling in INOX < 900 N/mm <sup>2</sup>	0.012 mm
Feed f <sub>z</sub> for copy milling in stainless steel < 900 N/mm <sup>2</sup>	0.013 mm
Shank Ø D <sub>s</sub>	6 mm
Overall length L	80 mm
Flute length L <sub>c</sub>	8 mm
Correction factor for v <sub>c</sub>	1.25
Helix angle	45 degrees
Radius R	2 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 <sup>2</sup>	suitable	250 m/min	P
Steel < 750 N/mm <sup>2</sup>	suitable	230 m/min	P
Steel < 900 N/mm <sup>2</sup>	suitable	200 m/min	P
Steel < 1100 N/mm <sup>2</sup>	suitable	160 m/min	P
INOX < 900 N/mm <sup>2</sup>	suitable	95 m/min	M
INOX > 900 N/mm <sup>2</sup>	suitable	85 m/min	M
wet maximum	suitable		
wet minimum	suitable		

## Services

Shank grinding Type HB	129100 HB
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