

Garant
Ball nose slot drill HSS-PM, TiAlN, Ø e8 DC: 4mm

Order data

Order number	194302 4
GTIN	4045197110053
Item class	11W

Description
Version:

Centre cutting edge geometry for plunging.
For the most demanding metal removal rates.

Note:

For milling concave slots or for milling radius transitions.
Suitable for use as a copy mill and for mould making.
 f_z for a_p $0.05 \times D$.

Technical description

Feed f_z for copy milling in steel $< 750 \text{ N/mm}^2$	0.012 mm
No. of teeth Z	2
Cutting edge $\varnothing D_c$	4 mm
Shank $\varnothing D_s$	6 mm
Overall length L	51 mm
Flute length L_c	7 mm
Helix angle	30 degrees
Radius R	2 mm
Coating	TiAlN
Tool material	HSS PM
Type	N

Tolerance nominal \varnothing	e8
Direction of infeed	horizontal, oblique and vertical
Cutting width a_e for milling operation	0.05×D for copy milling
Shank	DIN 1835 B to h6
Through-coolant	no
Colour ring	without
Type of product	Ball-nosed slot drill

User data

	Suitability	V_c	ISO code
Aluminium (short chipping)	suitable only under restricted conditions	138 m/min	N
Alu > 10% Si	suitable only under restricted conditions	110 m/min	N
Steel < 500 N/mm ²	suitable	83 m/min	P
Steel < 750 N/mm ²	suitable	64 m/min	P
Steel < 900 N/mm ²	suitable	64 m/min	P
Steel < 1100 N/mm ²	suitable	37 m/min	P
Steel < 1400 N/mm ²	suitable only under restricted conditions	32 m/min	P
INOX < 900 N/mm ²	suitable	23 m/min	M
INOX > 900 N/mm ²	suitable only under restricted conditions	18 m/min	M
GG(G)	suitable only under restricted conditions	55 m/min	K
CuZn	suitable only under restricted conditions	110 m/min	N
Uni	suitable		
wet maximum	suitable		
dry	suitable		

