

Garant
Ball nose slot drill HSS-PM, TiAlN, Ø e8 DC: 15mm

Order data

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|--------------|---------------|
| Order number | 194302 15 |
| GTIN | 4045197110169 |
| 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

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| Cutting edge Ø D_c | 15 mm |
| Feed f_z for copy milling in steel < 750 N/mm ² | 0.052 mm |
| No. of teeth Z | 2 |
| Shank Ø D_s | 14 mm |
| Overall length L | 73 mm |
| Flute length L_c | 16 mm |
| Helix angle | 30 degrees |
| Radius R | 7.5 mm |
| Coating | TiAlN |
| Tool material | HSS PM |
| Type | N |

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|---|----------------------------------|
| 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 | | |

