

**Garant**
**Solid carbide ball nose slot drill, uncoated, Ø DC: 1,5mm**

**Order data**

Order number	207106 1,5
GTIN	4045197540430
Item class	11X

**Technical description**

No. of teeth Z	2
Overhang length $L_1$ incl. recess	5 mm
Feed $f_z$ for side milling in steel $< 900 \text{ N/mm}^2$	0.006 mm
Cutting edge $\varnothing D_c$	1.5 mm
Recess $\varnothing D_1$	1.44 mm
Feed $f_z$ for copy milling in steel $< 900 \text{ N/mm}^2$	0.006 mm
Shank $\varnothing D_s$	6 mm
Overall length L	50 mm
Flute length $L_c$	2 mm
Helix angle	30 degrees
Radius R	0.75 mm
Coating	uncoated
Tool material	Solid carbide
Standard	Manufacturer's standard
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
Cutting width $a_e$ for milling operation	0.05×D for side milling
Shank	DIN 6535 HA to h6
Through-coolant	no
Colour ring	without
Type of product	Ball-nosed slot drill

## User data

	Suitability	$V_c$	ISO code
Alu plastics	suitable only under restricted conditions	230 m/min	N
Aluminium (short chipping)	suitable only under restricted conditions	180 m/min	N
Alu > 10% Si	suitable only under restricted conditions	140 m/min	N
Steel < 500 N/mm <sup>2</sup>	suitable	90 m/min	P
Steel < 750 N/mm <sup>2</sup>	suitable	80 m/min	P
Steel < 900 N/mm <sup>2</sup>	suitable	70 m/min	P
Steel < 1100 N/mm <sup>2</sup>	suitable	45 m/min	P
INOX < 900 N/mm <sup>2</sup>	suitable	40 m/min	M
INOX > 900 N/mm <sup>2</sup>	suitable only under restricted conditions	35 m/min	M
GG(G)	suitable	70 m/min	K
CuZn	suitable only under restricted conditions	160 m/min	N
Uni	suitable		
wet maximum	suitable		
wet minimum	suitable only under restricted conditions		

## Services

Shank grinding Type HB

129100 HB