

**Garant**
**Solid carbide ball nose slot drill, TiAlN, Ø DC: 1,2mm**

**Order data**

Order number	207115 1,2
GTIN	4045197229465
Item class	11X

**Technical description**

Feed $f_z$ for copy milling in steel < 900 N/mm <sup>2</sup>	0.006 mm
Overhang length $L_1$ incl. recess	3 mm
Feed $f_z$ for side milling in steel < 900 N/mm <sup>2</sup>	0.006 mm
Recess Ø $D_1$	1.15 mm
Cutting edge Ø $D_c$	1.2 mm
No. of teeth $Z$	2
Shank Ø $D_s$	6 mm
Overall length $L$	50 mm
Flute length $L_c$	2 mm
Helix angle	30 degrees
Radius $R$	0.6 mm
Coating	TiAlN
Tool material	Solid carbide
Standard	Manufacturer's standard
Type	N
Tolerance nominal Ø	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	0.05×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
Aluminium (short chipping)	suitable only under restricted conditions	350 m/min	N
Alu > 10% Si	suitable only under restricted conditions	250 m/min	N
Steel < 500 N/mm <sup>2</sup>	suitable	160 m/min	P
Steel < 750 N/mm <sup>2</sup>	suitable	140 m/min	P
Steel < 900 N/mm <sup>2</sup>	suitable	130 m/min	P
Steel < 1100 N/mm <sup>2</sup>	suitable	80 m/min	P
Steel < 1400 N/mm <sup>2</sup>	suitable	70 m/min	P
Steel < 55 HRC	suitable	50 m/min	H
INOX < 900 N/mm <sup>2</sup>	suitable	80 m/min	M
INOX > 900 N/mm <sup>2</sup>	suitable only under restricted conditions	70 m/min	M
GG(G)	suitable	120 m/min	K
CuZn	suitable only under restricted conditions	320 m/min	N
Uni	suitable		
wet maximum	suitable		
wet minimum	suitable only under restricted conditions		
dry	suitable only under restricted conditions		

Air

Suitable only under  
restricted conditions

**Services**

Shank grinding Type HB

129100 HB