

**Garant**
**Solid carbide ball nose slot drill HPC, TiAlN, Ø f8 DC / D S: 0,5/6mm**

**Order data**

|              |               |
|--------------|---------------|
| Order number | 207240 0,5/6  |
| GTIN         | 4045197126924 |
| Item class   | 11X           |

**Description**
**Version:**
**Precision ground for very high accuracy requirements.**

Tolerance: Radius contour =  $\pm 0.005$  mm.

**Note:**
**Recommended successor product is No. 207242.**
**Technical description**

|   |                         |
|---|-------------------------|
| Feed $f_z$ for copy milling in steel < 1100 N/mm <sup>2</sup> | 0.005 mm                |
| No. of teeth Z  | 2                       |
| Feed $f_z$ for side milling in steel < 1100 N/mm <sup>2</sup> | 0.0044 mm               |
| Cutting edge Ø D <sub>c</sub>                                 | 0.5 mm                  |
| Shank Ø D <sub>s</sub>  | 6 mm                    |
| Overall length L  | 54 mm                   |
| Flute length L <sub>c</sub>                                   | 1.5 mm                  |
| Helix angle   | 30 degrees              |
| Radius R  | 0.25 mm                 |
| Coating   | TiAlN                   |
| Tool material   | Solid carbide           |
| Standard  | Manufacturer's standard |
| Type  | H                       |

|   |                                  |
|---|----------------------------------|
| Tolerance nominal $\varnothing$           | f8                               |
| Direction of infeed                       | horizontal, oblique and vertical |
| Cutting width $a_e$ for milling operation | 0.5×D for side milling           |
| Cutting width $a_e$ for milling operation | 0.03×D for copy milling          |
| Shank                                     | DIN 6535 HA to h6                |
| Through-coolant                           | no                               |
| Machining strategy                        | HPC                              |
| Colour ring                               | without                          |
| Type of product                           | Ball-nosed slot drill            |

### User data

|                                | Suitability                               | $V_c$     | ISO code |
|--------------------------------|---|-----------|----------|
| Steel < 500 N/mm <sup>2</sup>  | Suitable                                  | 225 m/min | P        |
| Steel < 750 N/mm <sup>2</sup>  | Suitable                                  | 210 m/min | P        |
| Steel < 900 N/mm <sup>2</sup>  | suitable                                  | 180 m/min | P        |
| Steel < 1100 N/mm <sup>2</sup> | suitable                                  | 145 m/min | P        |
| Steel < 1400 N/mm <sup>2</sup> | suitable only under restricted conditions | 140 m/min | P        |
| INOX < 900 N/mm <sup>2</sup>   | suitable                                  | 85 m/min  | M        |
| INOX > 900 N/mm <sup>2</sup>   | suitable only under restricted conditions | 70 m/min  | M        |
| GG(G)                          | suitable only under restricted conditions | 350 m/min | K        |
| CuZn                           | suitable only under restricted conditions | 400 m/min | N        |
| wet maximum                    | Suitable                                  |           |          |
| wet minimum                    | suitable only under restricted conditions |           |          |
| dry                            | suitable                                  |           |          |
| Air                            | Suitable                                  |           |          |

## Services

Shank grinding Type HB

129100 HB