

**Garant**
**Solid carbide ball nose slot drill HPC, TiAlN, Ø f8 DC / D S: 4mm**

**Order data**

Order number	207240 4
GTIN	4045197127129
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 side milling in steel < 1100 N/mm <sup>2</sup>	0.032 mm
No. of teeth Z	2
Cutting edge Ø D <sub>c</sub>	4 mm
Feed $f_z$ for copy milling in steel < 1100 N/mm <sup>2</sup>	0.037 mm
Shank Ø D <sub>s</sub>	4 mm
Overall length L	54 mm
Flute length L <sub>c</sub>	8 mm
Helix angle	30 degrees
Radius R	2 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		

