

Garant
Solid carbide ball nose slot drill HPC, TiAlN, Ø f8 DC / D S: 4/6mm

Order data

Order number	207240 4/6
GTIN	4045197127136
Item class	11X

Description
Version:
Precision ground for very high accuracy requirements.

Tolerance: Radius contour = ± 0.005 mm.

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

Cutting edge $\varnothing D_c$	4 mm
No. of teeth Z	2
Feed f_z for side milling in steel < 1100 N/mm ²	0.032 mm
Feed f_z for copy milling in steel < 1100 N/mm ²	0.037 mm
Shank $\varnothing D_s$	6 mm
Overall length L	54 mm
Flute length L_c	8 mm
Correction factor for v_c	1.25
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 ²	Suitable	225 m/min	P
Steel < 750 N/mm ²	Suitable	210 m/min	P
Steel < 900 N/mm ²	suitable	180 m/min	P
Steel < 1100 N/mm ²	suitable	145 m/min	P
Steel < 1400 N/mm ²	suitable only under restricted conditions	140 m/min	P
INOX < 900 N/mm ²	suitable	85 m/min	M
INOX > 900 N/mm ²	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~~
Services

Suitable

Shank grinding Type HB

129100 HB