

**Garant**
**Solid carbide ball nose slot drill, Diamond, Ø f8 DC / DS: 1/6mm**

**Order data**

Order number	209776 1/6
GTIN	4045197544070
Item class	11Y

**Description**
**Version:**

With the latest generation of **crystalline diamond coating sp<sup>3</sup>**, for process reliability in machining **fibre-reinforced composites, CRP, GRP and graphite**. Double relief ground side clearance angle.

Tolerance: Radius contour = **±0.01 mm**.

**Technical description**

Feed $f_z$ for side milling in graphite	0.011 mm
Recess Ø $D_1$	0.95 mm
Overhang length $L_1$ incl. recess	3 mm
Feed $f_z$ for copy milling in graphite	0.011 mm
No. of teeth Z	2
Cutting edge Ø $D_c$	1 mm
Shank Ø $D_s$	6 mm
Overall length L	54 mm
Flute length $L_c$	2 mm
Correction factor for $v_c$	1.25
Helix angle	30 degrees
Radius R	0.5 mm
Coating	Diamond

Tool material	Solid carbide
Standard	Manufacturer's standard
Tolerance nominal $\varnothing$	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	0.2×D for side milling
Shank	DIN 6535 HA with h6
Through-coolant	no
Colour ring	black
Type of product	Ball-nosed slot drill

## User data

	Suitability	$V_c$	ISO code
PVDF GF20	suitable	200 m/min	N
POM GF25	suitable	190 m/min	N
PA 66 GF30	suitable	170 m/min	N
PEEK GF30	suitable	150 m/min	N
PTFE CF25	suitable	180 m/min	N
PEEK CF30	suitable	160 m/min	N
Hybrids	suitable		
Honeycomb sandwich	suitable	350 m/min	N
GRP	suitable	190 m/min	N
GRP, CRP	suitable	190 m/min	N
Graphite	suitable	340 m/min	N
wet minimum	suitable		
dry	Suitable		
Air	suitable		

## Services

Shank grinding Type HB

129100 HB