

Garant
Solid carbide ball nose slot drill, Diamond, Ø f8 DC / DS: 4/6mm

Order data

Order number	209781 4/6
GTIN	4045197544360
Item class	11Y

Description
Version:

With the latest generation of **crystalline diamond coating sp³**, 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 copy milling in graphite	0.023 mm
Recess $\varnothing D_1$	3.9 mm
Overhang length L_1 incl. recess	36 mm
Feed f_z for side milling in graphite	0.023 mm
No. of teeth Z	2
Cutting edge $\varnothing D_c$	4 mm
Shank $\varnothing D_s$	6 mm
Overall length L	80 mm
Flute length L_c	8 mm
Correction factor for v_c	1.25
Helix angle	30 degrees
Radius R	2 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