

**Garant**
**GARANT Master Titan solid carbide ball nose slot drill HPC, TiAlN, Ø f8 DC / DS: 6mm**

**Order data**

Order number	207482 6
GTIN	4045197989604
Item class	11Z

**Description**
**Version:**

**Special geometry** for machining **titanium and titanium alloys**.

4 centre cutting edges to the centre.

Therefore can be used as a **true 4-edge cutter** at all depths of cut.

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

**Note:**

Regrinding not recommended.

**Technical description**

Feed $f_z$ for copy milling in titanium $> 850$ N/mm <sup>2</sup>	0.024 mm
Flute length $L_c$	10 mm
Correction factor for $v_c$	1.25
Overall length $L$	54 mm
Cutting edge $\varnothing D_c$	6 mm
Shank $\varnothing D_s$	6 mm
No. of teeth $Z$	4
Feed $f_z$ for side milling in titanium $> 850$ N/mm <sup>2</sup>	0.02 mm
Helix angle	45 degrees
Radius $R$	3 mm

Coating	TiAlN
Tool material	Solid carbide
Standard	Manufacturer's standard
Type	N
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	0.05×D for side milling
Shank	DIN 6535 HA to h6
Through-coolant	no
Machining strategy	HPC
Colour ring	pink
Type of product	Ball-nosed slot drill

## User data

	Suitability	$V_c$	ISO code
Ti > 850 N/mm <sup>2</sup>	suitable	60 m/min	S
wet maximum	suitable		

## Services

Shank grinding Type HB	129100 HB
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