

Garant
GARANT Master Titan solid carbide ball nose slot drill HPC, TiAlN, Ø f8 DC / DS: 1mm

Order data

Order number	207482 1
GTIN	4045197989550
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 = ± 0.005 mm.

Note:

Regrinding not recommended.

Technical description

Overall length L	54 mm
Flute length L_c	2 mm
No. of teeth Z	4
Correction factor for v_c	1.25
Feed f_z for copy milling in titanium > 850 N/mm ²	0.012 mm
Feed f_z for side milling in titanium > 850 N/mm ²	0.01 mm
Shank $\varnothing D_s$	6 mm
Cutting edge $\varnothing D_c$	1 mm
Helix angle	45 degrees
Radius R	0.5 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 ²	suitable	60 m/min	S
wet maximum	suitable		

Services

Shank grinding Type HB	129100 HB
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