

Garant
GARANT Master Steel solid carbide ball nose slot drill HPC, TiAlN, Ø f8 DC / D S: 1,1mm

Order data

Order number	207242 1,1
GTIN	4062406284831
Item class	11X

Description
Version:
Precision ground for very high accuracy requirements.

Tolerance: Radius contour = ± 0.005 mm.

Improved cutting edge protection thanks to slight edge honing. Tremendous bending strength due to the use of ultra-fine grain substrate.

No. of teeth Z: 2

Helix angle: 28°

No. of teeth Z: 2

Flute length L_c : 2 mm

Overall length L: 50 mm

Shank $\varnothing D_s$: 3 mm

Feed f_z for side milling in steel < 900 N/mm²: 0.012 mm

Feed f_z for copy milling in steel < 900 N/mm²: 0.015 mm

Technical description

Shank $\varnothing D_s$	3 mm
Feed f_z for copy milling in steel < 900 N/mm ²	0.015 mm
Cutting edge $\varnothing D_c$	1.1 mm
Feed f_z for side milling in steel < 900 N/mm ²	0.012 mm
Flute length L_c	2 mm
Overall length L	50 mm

Helix angle	28 °
No. of teeth Z	2
Radius R	0.55 mm
Series	Master Steel
Coating	TiAlN
Tool material	Solid carbide
Standard	Manufacturer's standard
Type	N
Tolerance nominal Ø	f8
Direction of infeed	horizontal, oblique and vertical
Cutting width a_e for milling operation	Full slot cutting depth 1×D
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	green
Type of product	Ball-nosed slot drill

User data

	Suitability	V_c	ISO code
Steel < 500 N/mm ²	Suitable	270 m/min	P
Steel < 750 N/mm ²	Suitable	240 m/min	P
Steel < 900 N/mm ²	suitable	220 m/min	P
Steel < 1100 N/mm ²	suitable	190 m/min	P
Steel < 1400 N/mm ²	suitable	170 m/min	P
Steel < 55 HRC	suitable only under restricted conditions	140 m/min	H
INOX < 900 N/mm ²	suitable	90 m/min	M

INOX > 900 N/mm ²	suitable only under restricted conditions	80 m/min	M
GG(G)	suitable only under restricted conditions	400 m/min	K
Uni	Suitable		
wet maximum	Suitable		
wet minimum	suitable only under restricted conditions		
dry	suitable		
Air	Suitable		