

**Garant**
**GARANT Master Steel solid carbide ball nose slot drill HPC, TiAlN, Ø f8 DC / D S: 3mm**

**Order data**

Order number	207246 3
GTIN	4062406285241
Item class	11X

**Description**
**Version:**
**Precision ground for very high accuracy requirements.**

Tolerance: Radius contour =  $\pm 0.005$  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:  $28^\circ$

No. of teeth Z: 2

Flute length  $L_c$ : 5 mm

Overall length L: 100 mm

Shank  $\varnothing D_s$ : 3 mm

Feed  $f_z$  for side milling in steel  $< 900$  N/mm<sup>2</sup>: 0.04 mm

Feed  $f_z$  for copy milling in steel  $< 900$  N/mm<sup>2</sup>: 0.06 mm

**Technical description**

Feed $f_z$ for copy milling in steel $< 900$ N/mm <sup>2</sup>	0.06 mm
Helix angle	$28^\circ$
Shank $\varnothing D_s$	3 mm
Flute length $L_c$	5 mm
Overall length L	100 mm
Feed $f_z$ for side milling in steel $< 900$ N/mm <sup>2</sup>	0.04 mm
Cutting edge $\varnothing D_c$	3 mm

No. of teeth Z	2
Radius R	1.5 mm
Series	Master Steel
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	0.03×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 <sup>2</sup>	Suitable	250 m/min	P
Steel < 750 N/mm <sup>2</sup>	Suitable	220 m/min	P
Steel < 900 N/mm <sup>2</sup>	suitable	200 m/min	P
Steel < 1100 N/mm <sup>2</sup>	suitable	170 m/min	P
Steel < 1400 N/mm <sup>2</sup>	suitable	150 m/min	P
Steel < 55 HRC	suitable only under restricted conditions	120 m/min	H
INOX < 900 N/mm <sup>2</sup>	suitable	75 m/min	M
INOX > 900 N/mm <sup>2</sup>	suitable only under restricted conditions	70 m/min	M

GG(G)	suitable only under restricted conditions	300 m/min	K
Uni	Suitable		
wet maximum	suitable		
wet minimum	suitable only under restricted conditions		
dry	Suitable		
Air	Suitable		