

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

Order data

Order number	207492 3
GTIN	4062406285425
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: 4

Helix angle: 30 °

No. of teeth Z: 4

Flute length L_c : 5 mm

Overhang length L_1 incl. recess: 12 mm

Recess Ø D_1 : 2.8 mm

Overall length L: 75 mm

Shank Ø D_s : 4 mm

Technical description

No. of teeth Z	4
Shank Ø D_s	4 mm
Helix angle	30 °
Flute length L_c	5 mm
Cutting edge Ø D_c	3 mm
Overhang length L_1 incl. recess	12 mm
Feed f_z for side milling in steel < 900 N/mm ²	0.02 mm

Feed f_z for copy milling in steel $< 900 \text{ N/mm}^2$	0.025 mm
Recess $\varnothing D_1$	2.8 mm
Overall length L	75 mm
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	$0.03 \times D$ for copy milling
Cutting width a_e for milling operation	Full slot cutting depth $1 \times D$
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 $< 500 \text{ N/mm}^2$	suitable only under restricted conditions	270 m/min	P
Steel $< 750 \text{ N/mm}^2$	Suitable	240 m/min	P
Steel $< 900 \text{ N/mm}^2$	Suitable	220 m/min	P
Steel $< 1100 \text{ N/mm}^2$	suitable only under restricted conditions	190 m/min	P
Steel $< 1400 \text{ N/mm}^2$	suitable only under restricted conditions	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 only under restricted conditions		
Air	suitable only under restricted conditions		