

Garant
Solid carbide high precision ball nose slot drill, DLC, Ø DC: 4mm

Order data

Order number	207097 4
GTIN	4045197859518
Item class	11X

Description
Version:

With **DLC coating sp²** of the latest generation.

High precision ball nose slot drills in respect of **radius Ø and contour variations within the µm range.**

Tolerances: radius contour = **±0.005 mm.**

For the highest demands on dimensional accuracy of the workpiece.

Note:

Successor product to No. 207095.

Technical description

Shank Ø D _s	4 mm
Feed f _z for copy milling in short-chipping aluminium	0.03 mm
Overall length L	54 mm
Cutting edge Ø D _c	4 mm
Flute length L _c	7 mm
No. of teeth Z	2
Overhang length L ₁ incl. recess	17 mm
Recess Ø D ₁	3.7 mm
Helix angle	45 degrees
Radius R	2 mm
Coating	DLC

Tool material	Solid carbide
Standard	Manufacturer's standard
Type	W
Tolerance nominal \varnothing	-0.007 / 0.002
Direction of infeed	horizontal, oblique and vertical
Cutting width a_e for milling operation	0.03×D for copy milling
Shank	DIN 6535 HA to h6
Balance quality with shank	G 2.5 with HA
Through-coolant	no
Colour ring	yellow
Type of product	Ball-nosed slot drill

User data

	Suitability	V_c	ISO code
Aluminium	Suitable	600 m/min	N
Aluminium (short chipping)	suitable	550 m/min	N
Alu > 10% Si	suitable	500 m/min	N
PMMA acrylic	Suitable	220 m/min	N
PE-HD	Suitable	180 m/min	N
PA 66	Suitable	220 m/min	N
PEEK	Suitable	170 m/min	N
PF 31	Suitable	150 m/min	N
PVDF GF20	Suitable	200 m/min	N
POM GF25	Suitable	180 m/min	N
PA 66 GF30	Suitable	170 m/min	N
PEEK GF30	Suitable	140 m/min	N
PTFE CF25	Suitable	180 m/min	N

Honeycomb sandwich	suitable only under restricted conditions	320 m/min	N
Cu	Suitable	180 m/min	N
CuZn	Suitable	220 m/min	N
wet maximum	suitable		
wet minimum	Suitable		
dry	suitable only under restricted conditions		
Air	Suitable		