

Garant**Solid carbide ball nose slot drill, TiAlN, Ø DC: 4mm****Order data**

Order number	207115 4
GTIN	4045197229519
Item class	11X

Technical description

Cutting edge Ø D _c	4 mm
Recess Ø D ₁	3.9 mm
Overhang length L ₁ incl. recess	12 mm
Feed f _z for copy milling in steel < 900 N/mm ²	0.025 mm
No. of teeth Z	2
Feed f _z for side milling in steel < 900 N/mm ²	0.023 mm
Shank Ø D _s	6 mm
Overall length L	54 mm
Flute length L _c	8 mm
Helix angle	30 degrees
Radius R	2 mm
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	0.05×D for copy milling
Cutting width a_e for milling operation	0.05×D for side milling
Shank	DIN 6535 HA to h6
Through-coolant	no
Colour ring	without
Type of product	Ball-nosed slot drill

User data

	Suitability	V_c	ISO code
Aluminium (short chipping)	suitable only under restricted conditions	350 m/min	N
Alu > 10% Si	suitable only under restricted conditions	250 m/min	N
Steel < 500 N/mm ²	suitable	160 m/min	P
Steel < 750 N/mm ²	suitable	140 m/min	P
Steel < 900 N/mm ²	suitable	130 m/min	P
Steel < 1100 N/mm ²	suitable	80 m/min	P
Steel < 1400 N/mm ²	suitable	70 m/min	P
Steel < 55 HRC	suitable	50 m/min	H
INOX < 900 N/mm ²	suitable	80 m/min	M
INOX > 900 N/mm ²	suitable only under restricted conditions	70 m/min	M
GG(G)	suitable	120 m/min	K
CuZn	suitable only under restricted conditions	320 m/min	N
Uni	suitable		
wet maximum	suitable		
wet minimum	suitable only under restricted conditions		
dry	suitable only under restricted conditions		

Air	Suitable only under restricted conditions
Services	
Shank grinding Type HB	129100 HB