

Garant
**GARANT Master Steel solid carbide ball nose milling cutter HPC, TiAlN, Ø f8
DC: 8mm**

Order data

Order number	207490 8
GTIN	4062406285364
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.

Technical description

Recess $\varnothing D_1$	7.8 mm
Flute length L_c	12 mm
Helix angle	30 degrees
Feed f_z for side milling in steel < 900 N/mm ²	0.06 mm
Overhang length L_1 incl. recess	27 mm
No. of teeth Z	4
Feed f_z for copy milling in steel < 900 N/mm ²	0.065 mm
Cutting edge $\varnothing D_c$	8 mm
Overall length L	63 mm
Shank $\varnothing D_s$	8 mm
Radius R	4 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	$0.03 \times D$ 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 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	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