

Garant
Solid carbide ball nose slot drill, uncoated, Ø f8 DC: 4mm

Order data

Order number	207028 4
GTIN	4045197596635
Item class	11X

Description
Version:

Additionally **polish ground** in the flutes for **outstanding chip evacuation** in long-chipping aluminium components.

Dimensions similar to **DIN 6527**.

Technical description

Overhang length L_1 incl. recess	36 mm
Cutting edge $\varnothing D_c$	4 mm
Recess $\varnothing D_1$	3.7 mm
Feed f_z for copy milling in short-chipping aluminium	0.03 mm
No. of teeth Z	2
Shank $\varnothing D_s$	4 mm
Overall length L	75 mm
Flute length L_c	13 mm
Helix angle	45 degrees
Radius R	2 mm
Coating	uncoated
Tool material	Solid carbide
Standard	Manufacturer's standard
Type	W

Tolerance nominal \varnothing	f8
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	220 m/min	N
Aluminium (short chipping)	suitable	170 m/min	N
Alu > 10% Si	suitable	130 m/min	N
PMMA acrylic	Suitable	180 m/min	N
PE-HD	Suitable	140 m/min	N
PA 66	Suitable	180 m/min	N
PEEK	Suitable	130 m/min	N
PF 31	Suitable	120 m/min	N
Honeycomb sandwich	suitable only under restricted conditions	180 m/min	N
Cu	Suitable	140 m/min	N
CuZn	Suitable	180 m/min	N
wet maximum	suitable		
wet minimum	suitable only under restricted conditions		
dry	suitable only under restricted conditions		

Air

suitable only under
restricted conditions