

**Garant****Solid carbide ball nose milling cutter, DLC, Ø f8 DC: 5mm****Order data**

|              |               |
|--------------|---------------|
| Order number | 207441 5      |
| GTIN         | 4045197591050 |
| Item class   | 11X           |

**Description****Version:**

With the latest generation of **DLC coating sp<sup>2</sup>**. For **high-performance milling of aluminium materials**. 4 centre cutting edges to the centre. Therefore can be used as a true **4-edge drill** at all depths of cut.

Tolerance: Radius contour = **±0.005 mm**.

**Technical description**

|                                               |               |
|-----------------------------------------------|---------------|
| Feed $f_z$ for copy milling in cast aluminium | 0.06 mm       |
| Recess Ø $D_1$                                | 4.6 mm        |
| No. of teeth Z                                | 4             |
| Overhang length $L_1$ incl. recess            | 18 mm         |
| Cutting edge Ø $D_c$                          | 5 mm          |
| Shank Ø $D_s$                                 | 5 mm          |
| Overall length L                              | 54 mm         |
| Flute length $L_c$                            | 8 mm          |
| Helix angle                                   | 45 degrees    |
| Radius R                                      | 2.5 mm        |
| Coating                                       | DLC           |
| Tool material                                 | Solid carbide |

|                                           |                                  |
|-------------------------------------------|----------------------------------|
| Standard                                  | Manufacturer's standard          |
| Type                                      | W                                |
| Tolerance nominal Ø                       | f8                               |
| Direction of infeed                       | horizontal, oblique and vertical |
| Cutting width $a_e$ for milling operation | $0.1 \times D$ for copy milling  |
| Shank                                     | DIN 6535 HA to h6                |
| 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<br>restricted conditions |           |   |
| Air         | Suitable                                     |           |   |