Garant

GARANT Master Steel solid carbide ball nose end mill HPC, TiAlN, ∅ f8 DC: 2mm

Order data

Order number	207490 2
GTIN	4062406285319
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

No. of teeth Z	4
Recess ∅ D_1	1.8 mm
Shank ∅ D_s	4 mm
Helix angle	30 degrees
Overall length L	50 mm
Flute length L_c	4 mm

Overhang length L_1 incl. recess	8 mm
Feed f_z for copy milling in steel < 900 N/mm²	0.02 mm
Cutting edge ⌀ D_C	2 mm
Feed f_z for side milling in steel < 900 N/mm²	0.015 mm
Radius R	1 mm
Series	Master Steel
Coating	TiAlN
Tool material	Solid carbide
Standard	Manufacturer's standard
Type	N
Tolerance nominal ⌀	f8
Direction of infeed	horizontal, oblique and vertical
Cutting width a_e for milling operation	0.03×D for copy milling
Cutting width a_e for milling operation	Full slot cutting depth 1×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/mm²	Suitable	270 m/min	P
Steel < 750 N/mm²	Suitable	240 m/min	P
Steel < 900 N/mm²	suitable	220 m/min	P
Steel < 1100 N/mm²	suitable	190 m/min	P
Steel < 1400 N/mm²	Suitable	170 m/min	P
Steel < 55 HRC	suitable only under restricted conditions	140 m/min	H

INOX < 900 N/mm²	suitable	90 m/min	M
INOX > 900 N/mm²	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		