

Garant
GARANT Master INOX solid carbide slot drill HPC, TiAlN, Ø e8 DC: 4mm

Order data

Order number	201647 4
GTIN	4062406112974
Item class	11X

Description
Version:

Double relief ground **2 chamfers hollow ground** for use in **HPC applications**.

Greater oxidation resistance and high-temperature hardness.

Can be used at high cutting speeds, particularly suitable even for Toolox®.

Note:

Successor product to No. 201644.

Technical description

Overhang length L_1 incl. recess	15 mm
Direction of infeed	horizontal, oblique and vertical
Shank	DIN 6535 HA to h6
Cutting edge $\varnothing D_c$	4 mm
No. of teeth Z	2
Feed f_z for slot milling in stainless steel $< 900 \text{ N/mm}^2$	0.018 mm
Shank $\varnothing D_s$	6 mm
Flute length L_c	11 mm
Overall length L	57 mm
Helix angle	50 degrees
Recess $\varnothing D_1$	3.8 mm

Feed f_z for side milling in INOX < 900 N/mm ²	0.022 mm
Tolerance nominal \varnothing	e8
Corner chamfer width at 45°	0.05 mm
Corner chamfer angle	45 degrees
Series	Master INOX
Coating	TiAlN
Tool material	solid carbide
Standard	DIN 6527
Type	N
Cutting width a_e for milling operation	Full slot cutting depth 1xD
Cutting width a_e for milling operation	Full slot cutting depth 1xD
Through-coolant	no
Machining strategy	HPC
Colour ring	blue
Type of product	End / face mill

User data

	Suitability	V_c	ISO code
Steel < 500 N/mm ²	suitable	250 m/min	P
Steel < 750 N/mm ²	suitable	230 m/min	P
Steel < 900 N/mm ²	suitable	200 m/min	P
Steel < 1100 N/mm ²	suitable	170 m/min	P
Steel < 1400 N/mm ²	suitable	170 m/min	P
TOOLOX 33	suitable	115 m/min	H
TOOLOX 44	suitable	80 m/min	H
INOX < 900 N/mm ²	suitable	110 m/min	M
INOX > 900 N/mm ²	suitable	90 m/min	M
Uni	Suitable only under restricted conditions		

wet maximum	suitable
wet minimum	suitable only under restricted conditions
Air	suitable only under restricted conditions
Services	
Shank grinding Type HB	129100 HB