

Garant
GARANT Master Steel solid carbide slot drill, TiAlN, Ø DC: 1 mm

Order data

Order number	201646 1
GTIN	4062406297824
Item class	11X

Description
Version:
Eccentric relief ground for stronger cutting edges.

Dimensions similar to DIN 6527.

Advantage:
Optimised flute geometry for improved chip evacuation.

Note:
Successor product to No. 201645.
Technical description

Corner chamfer width at 45°	0.05 mm
Shank	DIN 6535 HA to h6
No. of teeth Z	2
Overall length L	38 mm
Recess Ø D ₁	0.9 mm
Feed f _z for side milling in steel < 750 N/mm ²	0.07 mm
Tolerance nominal Ø	f8
Shank Ø D _s	3 mm
Cutting edge Ø D _c	1 mm
Direction of infeed	horizontal, oblique and vertical
Flute length L _c	3 mm

Feed f_z for slot milling in steel < 750 N/mm ²	0.005 mm
Helix angle	38 degrees
Overhang length L_1 incl. recess	6 mm
Corner chamfer angle	90 degrees
Series	Master Steel
Coating	TiAlN
Tool material	Solid carbide
Standard	DIN 6527
Type	N
Cutting width a_e for milling operation	Full slot cutting depth 1×D
Cutting width a_e for milling operation	0.5×D for side milling
Through-coolant	no
Machining strategy	HPC
Colour ring	green
Type of product	End / face mill

User data

	Suitability	V_c	ISO code
Steel < 500 N/mm ²	suitable	260 m/min	P
Steel < 750 N/mm ²	suitable	240 m/min	P
Steel < 900 N/mm ²	suitable	190 m/min	P
Steel < 1100 N/mm ²	suitable	180 m/min	P
Steel < 1400 N/mm ²	suitable only under restricted conditions	150 m/min	P
INOX < 900 N/mm ²	suitable	80 m/min	M
INOX > 900 N/mm ²	suitable	70 m/min	M
GG(G)	suitable	250 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