

**Garant**
**GARANT Master Steel solid carbide slot drill, TiAlN, Ø DC: 4mm**

**Order data**

Order number	201646 4
GTIN	4062406297855
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**

Direction of infeed	horizontal, oblique and vertical
Shank	DIN 6535 HA to h6
No. of teeth Z	2
Cutting edge Ø D <sub>c</sub>	4 mm
Recess Ø D <sub>1</sub>	3.8 mm
Overall length L	57 mm
Shank Ø D <sub>s</sub>	6 mm
Flute length L <sub>c</sub>	8 mm
Feed f <sub>z</sub> for slot milling in steel < 750 N/mm <sup>2</sup>	0.02 mm
Corner chamfer angle	45 degrees
Overhang length L <sub>1</sub> incl. recess	14 mm

Feed $f_z$ for side milling in steel < 750 N/mm <sup>2</sup>	0.023 mm
Tolerance nominal $\varnothing$	f8
Helix angle	38 degrees
Corner chamfer width at 45°	0.1 mm
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 <sup>2</sup>	suitable	260 m/min	P
Steel < 750 N/mm <sup>2</sup>	suitable	240 m/min	P
Steel < 900 N/mm <sup>2</sup>	suitable	190 m/min	P
Steel < 1100 N/mm <sup>2</sup>	suitable	180 m/min	P
Steel < 1400 N/mm <sup>2</sup>	suitable only under restricted conditions	150 m/min	P
INOX < 900 N/mm <sup>2</sup>	suitable	80 m/min	M
INOX > 900 N/mm <sup>2</sup>	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
<b>Services</b>	
Shank grinding Type HB	129100 HB