

**Garant**
**GARANT Master Steel solid carbide slot drill, TiAlN, Ø DC: 12mm**

**Order data**

Order number	201646 12
GTIN	4062406297909
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°	0.1 mm
Flute length $L_c$	22 mm
Tolerance nominal $\varnothing$	f8
Feed $f_z$ for side milling in steel < 750 N/mm <sup>2</sup>	0.08 mm
Overall length L	83 mm
Corner chamfer angle	45 degrees
Direction of infeed	horizontal, oblique and vertical
Cutting edge $\varnothing D_c$	12 mm
Helix angle	38 degrees
No. of teeth Z	2
Recess $\varnothing D_1$	11.8 mm

Shank	DIN 6535 HA to h6
Feed $f_z$ for slot milling in steel < 750 N/mm <sup>2</sup>	0.06 mm
Shank $\varnothing D_s$	12 mm
Overhang length $L_1$ incl. recess	36 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 $1 \times D$
Cutting width $a_e$ for milling operation	$0.5 \times D$ 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