

Garant
GARANT Master Steel solid carbide slot drill, TiAlN, Ø DC: 8mm

Order data

Order number	201646 8
GTIN	4062406297886
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

Recess $\varnothing D_1$	7.8 mm
Feed f_z for side milling in steel $< 750 \text{ N/mm}^2$	0.045 mm
Overall length L	63 mm
Helix angle	38 degrees
Shank $\varnothing D_s$	8 mm
Direction of infeed	horizontal, oblique and vertical
Overhang length L_1 incl. recess	25 mm
No. of teeth Z	2
Shank	DIN 6535 HA to h6
Corner chamfer angle	45 degrees
Flute length L_c	16 mm

Feed f_z for slot milling in steel < 750 N/mm ²	0.04 mm
Cutting edge $\varnothing D_c$	8 mm
Tolerance nominal \varnothing	f8
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 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
Services	
Shank grinding Type HB	129100 HB