

**Garant**
**Slot drills HSS-PM, TiAlN, Ø e8 DC: 4,5mm**

**Order data**

Order number	191250 4,5
GTIN	4045197101020
Item class	11W

**Description**
**Version:**

Centre cutting teeth for plunging.

**Eccentric relief ground.**

For very high demands on the metal removal rate.

**Note:**

**Suitable for use as a slot drill** (tolerance e8) **or an end mill.**

**50 % higher metal removal rate** than 2 flute slot drills.

**Larger flutes** than multi-flute end mills (good for soft material). For milling keyways.

**Technical description**

Cutting edge Ø D <sub>c</sub>	4.5 mm
Feed f <sub>z</sub> for slot milling in steel < 750 N/mm <sup>2</sup>	0.007 mm
No. of teeth Z	3
Shank Ø D <sub>s</sub>	6 mm
Overall length L	55 mm
Flute length L <sub>c</sub>	11 mm
Direction of infeed	horizontal, oblique and vertical
Shank	DIN 1835 B to h6
Tolerance nominal Ø	e8
Helix angle	30 degrees
Corner chamfer angle	90 degrees

Coating	TiAlN
Tool material	HSS PM
Standard	DIN 844 B
Type	N
Through-coolant	no
Colour ring	without
Type of product	End / face mill

### User data

	Suitability	V <sub>c</sub>	ISO code
Aluminium (short chipping)	suitable only under restricted conditions	138 m/min	N
Alu > 10% Si	suitable only under restricted conditions	110 m/min	N
Steel < 500 N/mm <sup>2</sup>	suitable	83 m/min	P
Steel < 750 N/mm <sup>2</sup>	suitable	64 m/min	P
Steel < 900 N/mm <sup>2</sup>	suitable	64 m/min	P
Steel < 1100 N/mm <sup>2</sup>	suitable	37 m/min	P
Steel < 1400 N/mm <sup>2</sup>	suitable only under restricted conditions	32 m/min	P
INOX < 900 N/mm <sup>2</sup>	suitable	25 m/min	M
INOX > 900 N/mm <sup>2</sup>	suitable only under restricted conditions	18 m/min	M
GG(G)	suitable only under restricted conditions	55 m/min	K
CuZn	suitable only under restricted conditions	110 m/min	N
Uni	suitable		
wet maximum	suitable		
dry	suitable		

