

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

Order data

| | |
|--------------|---------------|
| Order number | 191250 5 |
| GTIN | 4045197101037 |
| 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

| | |
|---|----------------------------------|
| Feed f_z for slot milling in steel $< 750 \text{ N/mm}^2$ | 0.008 mm |
| No. of teeth Z | 3 |
| Cutting edge $\varnothing D_c$ | 5 mm |
| Shank $\varnothing D_s$ | 6 mm |
| Overall length L | 57 mm |
| Flute length L_c | 13 mm |
| Direction of infeed | horizontal, oblique and vertical |
| Shank | DIN 1835 B to h6 |
| Tolerance nominal \varnothing | 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 _c | 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 ² | suitable | 83 m/min | P |
| Steel < 750 N/mm ² | suitable | 64 m/min | P |
| Steel < 900 N/mm ² | suitable | 64 m/min | P |
| Steel < 1100 N/mm ² | suitable | 37 m/min | P |
| Steel < 1400 N/mm ² | suitable only under restricted conditions | 32 m/min | P |
| INOX < 900 N/mm ² | suitable | 25 m/min | M |
| INOX > 900 N/mm ² | 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 | | |

