

Garant
Slot drill, uncoated, \varnothing e8 DC: 8,5mm

Order data

Order number	191100 8,5
GTIN	4045197100498
Item class	11W

Description
Version:

Centre cutting edge geometry for plunging. Wide, fine ground chip flutes. Exceptionally fine component surface finish - due to precisely ground cutting edges. For slots or for milling pockets from the component centre.

Note:

Note! Only for use in climb milling.

Technical description

Cutting edge $\varnothing D_c$	8.5 mm
Number of effective teeth Z (peripheral side)	2
Feed f_z for slot milling in short-chipping aluminium	0.024 mm
Shank $\varnothing D_s$	10 mm
Flute length L_c	19 mm
Overall length L	69 mm
Coating	uncoated
Tool material	HSS Co 8
Standard	DIN 844 B
Type	W
Tolerance nominal \varnothing	e8
Helix angle	42 degrees

Direction of infeed	horizontal, oblique and vertical
Shank	DIN 1835 B to h6
Through-coolant	no
Shank tolerance	h6
Corner chamfer angle	90 degrees
Colour ring	yellow
Type of product	Milling cutter

User data

	Suitability	V_c	ISO code
Aluminium (short chipping)	suitable	150 m/min	N
Alu > 10% Si	suitable only under restricted conditions	37 m/min	N
Steel < 500 N/mm ²	suitable	28 m/min	P
wet maximum	suitable		
wet minimum	suitable		