

Garant
Slot drills HSS-Co8, uncoated, Ø e8 DC: 22mm

Order data

Order number	191200 22
GTIN	4045197100900
Item class	11W

Description
Version:

Centre cutting teeth for plunging.

Eccentric relief ground.
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 $< 750 \text{ N/mm}^2$	0.035 mm
No. of teeth Z	3
Cutting edge Ø D_c	22 mm
Shank Ø D_s	20 mm
Overall length L	104 mm
Flute length L_c	38 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	uncoated
Tool material	HSS Co 8
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	83 m/min	N
Steel < 500 N/mm ²	suitable	30 m/min	P
Steel < 750 N/mm ²	suitable	25 m/min	P
Steel < 900 N/mm ²	suitable only under restricted conditions	23 m/min	P
GG(G)	suitable only under restricted conditions	23 m/min	K
CuZn	suitable only under restricted conditions	55 m/min	N
Uni	suitable		
wet maximum	suitable		