

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

**Order data**

Order number	191280 22
GTIN	4045197101624
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 N/mm <sup>2</sup>	0.04 mm
No. of teeth Z	3
Cutting edge Ø D <sub>c</sub>	22 mm
Shank Ø D <sub>s</sub>	20 mm
Overall length L	141 mm
Flute length L <sub>c</sub>	75 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 <sub>c</sub>	ISO code
Aluminium (short chipping)	suitable only under restricted conditions	83 m/min	N
Steel < 500 N/mm <sup>2</sup>	suitable	28 m/min	P
Steel < 750 N/mm <sup>2</sup>	suitable	25 m/min	P
Steel < 900 N/mm <sup>2</sup>	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		