

**Garant**
**Slot drills HSS-PM, TiAlN, Ø e8 DC: 3mm**

**Order data**

Order number	191290 3
GTIN	4045197531209
Item class	11W

**Description**
**Version:**

Centre cutting teeth for plunging.

**Eccentric relief ground.**

For the most demanding metal removal rates.

**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 $< 750 \text{ N/mm}^2$	0.003 mm
No. of teeth Z	3
Cutting edge $\varnothing D_c$	3 mm
Shank $\varnothing D_s$	6 mm
Overall length L	56 mm
Flute length $L_c$	12 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 <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	23 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		

