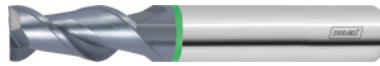



**Solid carbide slot drill, TiAlN, Ø DC: 4mm**

**Order data**

|              |               |
|--------------|---------------|
| Order number | 201650 4      |
| GTIN         | 4045197113573 |
| Item class   | 12X           |

**Description**
**Version:**

**Eccentric relief ground for stronger cutting edges.**

Dimensions similar to DIN 6527.

**Technical description**

|   |                                  |
|---|----------------------------------|
| Feed $f_z$ for slot milling in steel $< 750 \text{ N/mm}^2$ | 0.02 mm                          |
| Cutting edge $\varnothing D_c$                              | 4 mm                             |
| Corner chamfer width at $45^\circ$                          | 0.1 mm                           |
| No. of teeth Z  | 2                                |
| Feed $f_z$ for side milling in steel $< 750 \text{ N/mm}^2$ | 0.023 mm                         |
| Shank $\varnothing D_s$                                     | 6 mm                             |
| Overall length L  | 57 mm                            |
| Flute length $L_c$  | 11 mm                            |
| Direction of infeed   | horizontal, oblique and vertical |
| Shank   | DIN 6535 HA to h6                |
| Tolerance nominal $\varnothing$                             | h10                              |
| Helix angle   | 45 degrees                       |
| Corner chamfer angle  | 45 degrees                       |
| Coating   | TiAlN                            |

|   |                             |
|---|-----------------------------|
| Tool material                             | Solid carbide               |
| Standard                                  | DIN 6527                    |
| Type                                      | N                           |
| Cutting width $a_e$ for milling operation | 0.5×D for side milling      |
| Cutting width $a_e$ for milling operation | Full slot cutting depth 1×D |
| Through-coolant                           | no                          |
| Colour ring                               | green                       |
| Type of product                           | End / face mill             |

### User data

|                               | Suitability                               | $V_c$     | ISO code |
|-------------------------------|---|-----------|----------|
| Aluminium (short chipping)    | suitable only under restricted conditions | 280 m/min | N        |
| Alu > 10% Si                  | suitable only under restricted conditions | 200 m/min | N        |
| Steel < 500 N/mm <sup>2</sup> | suitable                                  | 120 m/min | P        |
| Steel < 750 N/mm <sup>2</sup> | suitable                                  | 105 m/min | P        |
| Steel < 900 N/mm <sup>2</sup> | suitable                                  | 100 m/min | P        |
| INOX < 900 N/mm <sup>2</sup>  | suitable                                  | 80 m/min  | M        |
| INOX > 900 N/mm <sup>2</sup>  | suitable                                  | 60 m/min  | M        |
| GG(G)                         | suitable only under restricted conditions | 90 m/min  | K        |
| Uni                           | suitable                                  |           |          |
| wet maximum                   | suitable                                  |           |          |
| wet minimum                   | suitable only under restricted conditions |           |          |
| dry                           | suitable only under restricted conditions |           |          |
| Air                           | suitable only under restricted conditions |           |          |

### Services

Shank grinding Type HB

129100 HB