

**Garant**
**Solid carbide slot drill HPC, TiAlN, Ø e8 DC: 5mm**

**Order data**

Order number	201644 5
GTIN	4045197353665
Item class	11X

**Description**
**Version:**

**Double** relief ground **2 chamfers hollow ground** for use in **HPC applications**.

**Technical description**

Corner chamfer width at 45°	0.08 mm
Feed $f_z$ for side milling in INOX < 900 N/mm <sup>2</sup>	0.022 mm
Cutting edge Ø $D_c$	5 mm
Feed $f_z$ for slot milling in stainless steel < 900 N/mm <sup>2</sup>	0.018 mm
No. of teeth Z	2
Overhang length $L_1$ incl. recess	21 mm
Recess Ø $D_1$	4.8 mm
Shank Ø $D_s$	6 mm
Overall length L	57 mm
Flute length $L_c$	13 mm
Direction of infeed	horizontal, oblique and vertical
Shank	DIN 6535 HA to h6
Tolerance nominal Ø	e8
Helix angle	50 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
Machining strategy	HPC
Colour ring	blue
Type of product	End / face mill

## User data

	Suitability	$V_c$	ISO code
Steel < 500 N/mm <sup>2</sup>	suitable	250 m/min	P
Steel < 750 N/mm <sup>2</sup>	suitable	220 m/min	P
Steel < 900 N/mm <sup>2</sup>	suitable	200 m/min	P
Steel < 1100 N/mm <sup>2</sup>	suitable	180 m/min	P
Steel < 1400 N/mm <sup>2</sup>	suitable	170 m/min	P
INOX < 900 N/mm <sup>2</sup>	suitable	90 m/min	M
INOX > 900 N/mm <sup>2</sup>	suitable	80 m/min	M
Uni	suitable		
wet maximum	suitable		
wet minimum	suitable only under restricted conditions		
Air	Suitable only under restricted conditions		

## Services

Shank grinding Type HB	129100 HB
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