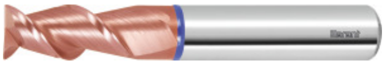
Garant

Solid carbide slot drill HPC, TiAlN, ∅ e8 DC: 6mm



Order data

Order number	201644 6
GTIN	4045197353672
Item class	11X

Description

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

Technical description

Recess ∅ D_1	5.8 mm
Corner chamfer width at 45°	0.15 mm
Overhang length L_1 incl. recess	21 mm
No. of teeth Z	2
Feed f_z for slot milling in stainless steel < 900 N/mm^2	0.035 mm
Cutting edge ∅ D_C	6 mm
Feed f_z for side milling in INOX < 900 N/mm^2	0.04 mm
Shank ∅ 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 ∅	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/mm²	suitable	250 m/min	P
Steel < 750 N/mm²	suitable	220 m/min	P
Steel < 900 N/mm²	suitable	200 m/min	P
Steel < 1100 N/mm²	suitable	180 m/min	P
Steel < 1400 N/mm²	suitable	170 m/min	P
INOX < 900 N/mm²	suitable	90 m/min	M
INOX > 900 N/mm²	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