


Solid carbide mini slot drill, TiAlN, Ø h10 DC: 1,2mm

Order data

Order number	201842 1,2
GTIN	4045197543431
Item class	12X

Description
Version:

Weldon shank **similar to DIN 6535 HB.**

Economy version.
Note:
Save on regrinding costs:

It is cheaper to use solid carbide mini slot drills to the wear limit than to regrind them.

Technical description

Feed f_z for slot milling in steel < 900 N/mm ²	0.005 mm
Feed f_z for side milling in steel < 900 N/mm ²	0.006 mm
No. of teeth Z	3
Shank form	HA
Cutting edge Ø D_c	1.2 mm
Shank Ø D_s	3 mm
Overall length L	38 mm
Flute length L_c	2 mm
Direction of infeed	horizontal, oblique and vertical
Correction factor for v_c	1.25
Shank	DIN 6535 HA to h6
Tolerance nominal Ø	h10

Helix angle	30 degrees
Corner chamfer angle	90 degrees
Coating	TiAlN
Tool material	Solid carbide
Standard	Manufacturer's standard
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	without
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 ²	suitable	120 m/min	P
Steel < 750 N/mm ²	suitable	105 m/min	P
Steel < 900 N/mm ²	suitable	100 m/min	P
Steel < 1100 N/mm ²	suitable	70 m/min	P
INOX < 900 N/mm ²	suitable	80 m/min	M
INOX > 900 N/mm ²	suitable only under restricted conditions	60 m/min	M
GG(G)	suitable	90 m/min	K
Uni	suitable		
wet maximum	suitable		
wet minimum	suitable only under restricted conditions		

dry

suitable only under
restricted conditions