


Solid carbide mini slot drill, TiAlN, Ø h10 DC: 1,8mm

Order data

Order number	201842 1,8
GTIN	4045197543455
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 side milling in steel $< 900 \text{ N/mm}^2$	0.006 mm
Shank form	HA
No. of teeth Z	3
Cutting edge $\varnothing D_c$	1.8 mm
Feed f_z for slot milling in steel $< 900 \text{ N/mm}^2$	0.005 mm
Shank $\varnothing D_s$	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 \varnothing	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