


Solid carbide mini slot drill, TiAlN, Ø e8 DC: 1,5mm

Order data

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| Order number | 201920 1,5 |
| GTIN | 4045197114778 |
| Item class | 12X |

Description
Version:

Double relief ground side clearance angle. Centre cutting teeth for plunging.

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

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

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|---|----------------------------------|
| Feed f_z for side milling in steel $< 900 \text{ N/mm}^2$ | 0.006 mm |
| Feed f_z for slot milling in steel $< 900 \text{ N/mm}^2$ | 0.005 mm |
| Corner chamfer width at 45° | 0.02 mm |
| Cutting edge $\varnothing D_c$ | 1.5 mm |
| No. of teeth Z | 3 |
| Shank form | HA |
| Shank $\varnothing D_s$ | 3 mm |
| Overall length L | 38 mm |
| Flute length L_c | 3 mm |
| Direction of infeed | horizontal, oblique and vertical |
| Correction factor for v_c | 1.25 |
| Shank | DIN 6535 HA to h6 |

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|---|-----------------------------|
| Tolerance nominal \varnothing | e8 |
| Helix angle | 45 degrees |
| Corner chamfer angle | 45 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 | | |

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|-------------|---|
| wet minimum | suitable only under restricted conditions |
| dry | suitable |