


**Solid carbide mini slot drill, TiAlN, Ø e8 DC: 4mm**

**Order data**

Order number	201920 4
GTIN	4045197114839
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**

Feed $f_z$ for side milling in steel $< 900 \text{ N/mm}^2$	0.023 mm
Corner chamfer width at $45^\circ$	0.03 mm
Feed $f_z$ for slot milling in steel $< 900 \text{ N/mm}^2$	0.02 mm
Shank form	HB
Cutting edge $\varnothing D_c$	4 mm
No. of teeth Z	3
Shank $\varnothing D_s$	6 mm
Overall length L	45 mm
Flute length $L_c$	7 mm
Direction of infeed	horizontal, oblique and vertical
Correction factor for $v_c$	1.25
Shank	DIN 6535 HB to h6

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 <sup>2</sup>	suitable	120 m/min	P
Steel < 750 N/mm <sup>2</sup>	suitable	105 m/min	P
Steel < 900 N/mm <sup>2</sup>	suitable	100 m/min	P
Steel < 1100 N/mm <sup>2</sup>	suitable	70 m/min	P
INOX < 900 N/mm <sup>2</sup>	suitable	80 m/min	M
INOX > 900 N/mm <sup>2</sup>	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