


Solid carbide mini slot drill, TiAlN, Ø e8 DC: 1,4mm

Order data

Order number	201920 1,4
GTIN	4045197645869
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

Shank form	HA
No. of teeth Z	3
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
Cutting edge Ø D_c	1.4 mm
Corner chamfer width at 45°	0.02 mm
Shank Ø 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

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		

wet minimum	suitable only under restricted conditions
dry	suitable