HOLEX

Solid carbide mini slot drill, TiAlN, ⌀ e8 DC: 9,7mm

Order data

Order number	201920 9,7
GTIN	4045197114952
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

Cutting edge ⌀ D_C	9.7 mm
Feed f_z for slot milling in steel < 900 N/mm^2	0.04 mm
Corner chamfer width at 45°	0.05 mm
No. of teeth Z	3
Feed f_z for side milling in steel < 900 N/mm^2	0.045 mm
Shank form	HB
Shank ⌀ D_s	10 mm
Overall length L	55 mm
Flute length L_c	16 mm
Direction of infeed	horizontal, oblique and vertical
Correction factor for v_c	1.25
Shank	DIN 6535 HB to h6

Tolerance nominal ∅	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/mm²	suitable	120 m/min	P
Steel < 750 N/mm²	suitable	105 m/min	P
Steel < 900 N/mm²	suitable	100 m/min	P
Steel < 1100 N/mm²	suitable	70 m/min	P
INOX < 900 N/mm²	suitable	80 m/min	M
INOX > 900 N/mm²	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