

Garant
Solid carbide slot drill DIN 6535 HA, TiAlN, Ø e8 DC: 4mm

Order data

Order number	202170 4
GTIN	4045197454669
Item class	11X

Description
Version:
Eccentric relief ground.

Dimensions similar to DIN 6527.

 Tolerance: Size nominal Ø $D_c = e8$.

Technical description

Recess Ø D_1	3.9 mm
Feed f_z for side milling in steel < 900 N/mm ²	0.023 mm
Feed f_z for slot milling in steel < 900 N/mm ²	0.02 mm
Overhang length L_1 incl. recess	15 mm
No. of teeth Z	3
Cutting edge Ø D_c	4 mm
Shank Ø D_s	6 mm
Overall length L	54 mm
Flute length L_c	8 mm
Direction of infeed	horizontal, oblique and vertical
Correction factor for v_c	1.25
Shank	DIN 6535 HA to h6
Tolerance nominal Ø	e8

Helix angle	45 degrees
Corner chamfer angle	90 degrees
Coating	TiAlN
Tool material	Solid carbide
Standard	DIN 6527
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
Steel < 1400 N/mm ²	suitable only under restricted conditions	60 m/min	P
Steel < 55 HRC	suitable only under restricted conditions	35 m/min	H
INOX < 900 N/mm ²	suitable	80 m/min	M
INOX > 900 N/mm ²	suitable	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
Services	
Shank grinding Type HB	129100 HB