

**Garant**
**Solid carbide slot drill DIN 6535 HA, TiAlN, Ø DC: 18mm**

**Order data**

Order number	202280 18
GTIN	4045197116482
Item class	11X

**Description**
**Version:**
**Eccentric relief ground.**

 Dimensions similar to **DIN 6527 long series.**

 Tolerance: Size nominal Ø  $D_c = e8$ .

**Technical description**

Overhang length $L_1$ incl. recess	44 mm
Recess Ø $D_1$	17.7 mm
Corner chamfer width at 45°	0.1 mm
Feed $f_z$ for slot milling in steel < 900 N/mm <sup>2</sup>	0.08 mm
Cutting edge Ø $D_c$	18 mm
Feed $f_z$ for side milling in steel < 900 N/mm <sup>2</sup>	0.1 mm
No. of teeth $Z$	3
Shank Ø $D_s$	18 mm
Overall length $L$	92 mm
Flute length $L_c$	32 mm
Direction of infeed	horizontal, oblique and vertical
Correction factor for $v_c$	1.5
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	DIN 6527
Type	N
Cutting width $a_e$ for milling operation	0.5xD for side milling
Cutting width $a_e$ for milling operation	Full slot cutting depth 1xD
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
Steel < 1400 N/mm <sup>2</sup>	suitable	60 m/min	P
Steel < 55 HRC	suitable only under restricted conditions	35 m/min	H
INOX < 900 N/mm <sup>2</sup>	suitable	80 m/min	M
INOX > 900 N/mm <sup>2</sup>	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
<b>Services</b>	
Shank grinding Type HB	129100 HB