

Garant
Solid carbide slot drill DIN 6535 HA, TiAlN, Ø DC: 8,5mm

Order data

Order number	202280 8,5
GTIN	4045197116413
Item class	11X

Description
Version:
Eccentric relief ground.

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

 Tolerance: Size nominal Ø $D_c = e8$.

Technical description

Feed f_z for side milling in steel < 900 N/mm ²	0.045 mm
No. of teeth Z	3
Overhang length L_1 incl. recess	32 mm
Recess Ø D_1	8.3 mm
Cutting edge Ø D_c	8.5 mm
Corner chamfer width at 45°	0.1 mm
Feed f_z for slot milling in steel < 900 N/mm ²	0.04 mm
Shank Ø D_s	10 mm
Overall length L	72 mm
Flute length L_c	19 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	0.5×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	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