

Garant
Slot drill HSS-PM, TiAlN, Ø e8 DC: 4mm

Order data

Order number	191050 4
GTIN	4045197099402
Item class	11W

Description
Version:

Centre cutting edge geometry for plunging.
For very high demands on the metal removal rate.

Application:

For milling **keyways** (slots) or pockets from the centre of the component.

Technical description

Feed f_z for slot milling in steel $< 750 \text{ N/mm}^2$	0.009 mm
Number of effective teeth Z (peripheral side)	2
Cutting edge $\varnothing D_c$	4 mm
Shank $\varnothing D_s$	6 mm
Flute length L_c	7 mm
Overall length L	51 mm
Coating	TiAlN
Tool material	HSS PM
Standard	DIN 327 D
Type	N
Tolerance nominal \varnothing	e8
Helix angle	30 degrees
Direction of infeed	horizontal, oblique and vertical

Shank	DIN 1835 B to h6
Through-coolant	no
Shank tolerance	h6
Corner chamfer angle	90 degrees
Colour ring	without
Type of product	Milling cutter

User data

	Suitability	V _c	ISO code
Aluminium (short chipping)	suitable only under restricted conditions	138 m/min	N
Alu > 10% Si	suitable only under restricted conditions	110 m/min	N
Steel < 500 N/mm ²	suitable	83 m/min	P
Steel < 750 N/mm ²	suitable	64 m/min	P
Steel < 900 N/mm ²	suitable	64 m/min	P
Steel < 1100 N/mm ²	suitable	37 m/min	P
Steel < 1400 N/mm ²	suitable only under restricted conditions	32 m/min	P
INOX < 900 N/mm ²	suitable	23 m/min	M
INOX > 900 N/mm ²	suitable only under restricted conditions	18 m/min	M
GG(G)	suitable only under restricted conditions	55 m/min	K
CuZn	suitable only under restricted conditions	110 m/min	N
Uni	suitable		
wet maximum	suitable		
dry	suitable		

