

**Garant**
**Slot drill HSS-PM, TiAlN, Ø e8 DC: 4,8mm**

**Order data**

Order number	191050 4,8
GTIN	4045197099426
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**

Cutting edge Ø D <sub>c</sub>	4.8 mm
Number of effective teeth Z (peripheral side)	2
Feed f <sub>z</sub> for slot milling in steel < 750 N/mm <sup>2</sup>	0.009 mm
Shank Ø D <sub>s</sub>	6 mm
Flute length L <sub>c</sub>	8 mm
Overall length L	52 mm
Coating	TiAlN
Tool material	HSS PM
Standard	DIN 327 D
Type	N
Tolerance nominal Ø	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 <sub>c</sub>	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 <sup>2</sup>	suitable	83 m/min	P
Steel < 750 N/mm <sup>2</sup>	suitable	64 m/min	P
Steel < 900 N/mm <sup>2</sup>	suitable	64 m/min	P
Steel < 1100 N/mm <sup>2</sup>	suitable	37 m/min	P
Steel < 1400 N/mm <sup>2</sup>	suitable only under restricted conditions	32 m/min	P
INOX < 900 N/mm <sup>2</sup>	suitable	23 m/min	M
INOX > 900 N/mm <sup>2</sup>	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		

