

**Garant**
**Solid carbide slot drill, TiAlN, Ø DC: 0,8mm**


## Order data

Order number	201630 0,8
GTIN	4045197264077
Item class	11X

## Description

### Version:

**Eccentric relief ground for stronger cutting edges.**

Size 0.25 to 2.5 - with double relief ground side clearance angle.

Tolerance: Size nominal Ø  $D_c = e8$ .

### Application:

**The intermediate sizes are especially for milling keyway slots.**

## Technical description

No. of teeth Z	2
Feed $f_z$ for side milling in steel < 900 N/mm <sup>2</sup>	0.003 mm
Shank form	HA
Feed $f_z$ for slot milling in steel < 900 N/mm <sup>2</sup>	0.003 mm
Cutting edge Ø $D_c$	0.8 mm
Shank Ø $D_s$	3 mm
Overall length L	38 mm
Flute length $L_c$	2 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	30 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 <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
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