

Garant
Solid carbide slot drill, TiAlN, Ø DC: 0,25mm


Order data

Order number	201630 0,25
GTIN	4045197264008
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

Shank form	HA
Cutting edge Ø D_c	0.25 mm
Feed f_z for slot milling in steel < 900 N/mm ²	0.001 mm
Feed f_z for side milling in steel < 900 N/mm ²	0.001 mm
No. of teeth Z	2
Shank Ø D_s	3 mm
Overall length L	38 mm
Flute length L_c	0.5 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 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
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