

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

**Order data**

Order number	191050 8
GTIN	4045197099518
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 $< 750 \text{ N/mm}^2$	0.02 mm
Number of effective teeth Z (peripheral side)	2
Cutting edge $\varnothing D_c$	8 mm
Shank $\varnothing D_s$	10 mm
Flute length $L_c$	11 mm
Overall length L	61 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 <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		

