

Garant
Slot drill, uncoated, Ø e8 DC: 8,5mm

Order data

Order number	191080 8,5
GTIN	4045197100139
Item class	11W

Description
Version:

Dimensions to **DIN 844 long**.

Cutting length to **DIN 844 short**.

Centre cutting edge geometry for plunging.

Application:

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

Technical description

Cutting edge Ø D _c	8.5 mm
Number of effective teeth Z (peripheral side)	2
Feed f _z for slot milling in steel < 750 N/mm ²	0.018 mm
Shank Ø D _s	10 mm
Flute length L _c	19 mm
Overall length L	88 mm
Coating	uncoated
Tool material	HSS Co 8
Standard	DIN 844 B
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 _c	ISO code
Aluminium (short chipping)	suitable only under restricted conditions	83 m/min	N
Steel < 500 N/mm ²	suitable	28 m/min	P
Steel < 750 N/mm ²	suitable	25 m/min	P
Steel < 900 N/mm ²	suitable only under restricted conditions	23 m/min	P
GG(G)	suitable only under restricted conditions	23 m/min	K
CuZn	suitable only under restricted conditions	55 m/min	N
wet maximum	suitable		