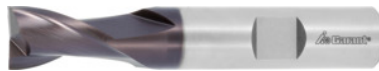


Garant
Slot drill HSS-PM, TiAlN, Ø e8 DC: 13mm

Order data

| | |
|--------------|---------------|
| Order number | 191050 13 |
| GTIN | 4045197099600 |
| 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 _c | 13 mm |
| Number of effective teeth Z (peripheral side) | 2 |
| Feed f _z for slot milling in steel < 750 N/mm ² | 0.038 mm |
| Shank Ø D _s | 12 mm |
| Flute length L _c | 16 mm |
| Overall length L | 73 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 _c | 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 ² | suitable | 83 m/min | P |
| Steel < 750 N/mm ² | suitable | 64 m/min | P |
| Steel < 900 N/mm ² | suitable | 64 m/min | P |
| Steel < 1100 N/mm ² | suitable | 37 m/min | P |
| Steel < 1400 N/mm ² | suitable only under restricted conditions | 32 m/min | P |
| INOX < 900 N/mm ² | suitable | 23 m/min | M |
| INOX > 900 N/mm ² | 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 | | |

