

Garant
Solid carbide slot drill, TiAlN, Ø DC: 2,5mm

Order data

Order number	201630 2,5
GTIN	4045197264176
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 $\varnothing D_c = e8$.

Application:

The intermediate sizes are especially for milling keyway slots.

Technical description

Shank form	HA
No. of teeth Z	2
Feed f_z for side milling in steel $< 900 \text{ N/mm}^2$	0.011 mm
Feed f_z for slot milling in steel $< 900 \text{ N/mm}^2$	0.01 mm
Cutting edge $\varnothing D_c$	2.5 mm
Shank $\varnothing D_s$	3 mm
Overall length L	50 mm
Flute length L_c	6 mm
Direction of infeed	horizontal, oblique and vertical
Correction factor for v_c	1.25
Shank	DIN 6535 HA to h6
Tolerance nominal \varnothing	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