

**Garant**
**Solid carbide slot drill DIN 6535 HA, TiAlN, Ø e8 DC: 10mm**

**Order data**

|              |               |
|--------------|---------------|
| Order number | 202170 10     |
| GTIN         | 4045197454706 |
| Item class   | 11X           |

**Description**
**Version:**
**Eccentric relief ground.**

Dimensions similar to DIN 6527.

 Tolerance: Size nominal Ø  $D_c = e8$ .

**Technical description**

|  |                                  |
|--|----------------------------------|
| Cutting edge Ø $D_c$   | 10 mm                            |
| No. of teeth Z   | 3                                |
| Feed $f_z$ for slot milling in steel < 900 N/mm <sup>2</sup> | 0.05 mm                          |
| Feed $f_z$ for side milling in steel < 900 N/mm <sup>2</sup> | 0.06 mm                          |
| Recess Ø $D_1$   | 9.7 mm                           |
| Overhang length $L_1$ incl. recess                           | 24 mm                            |
| Shank Ø $D_s$  | 10 mm                            |
| Overall length L   | 66 mm                            |
| Flute length $L_c$   | 14 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                               | 45 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 <sup>2</sup>  | suitable                                  | 120 m/min | P        |
| Steel < 750 N/mm <sup>2</sup>  | suitable                                  | 105 m/min | P        |
| Steel < 900 N/mm <sup>2</sup>  | suitable                                  | 100 m/min | P        |
| Steel < 1100 N/mm <sup>2</sup> | suitable                                  | 70 m/min  | P        |
| Steel < 1400 N/mm <sup>2</sup> | suitable only under restricted conditions | 60 m/min  | P        |
| Steel < 55 HRC                 | suitable only under restricted conditions | 35 m/min  | H        |
| INOX < 900 N/mm <sup>2</sup>   | suitable                                  | 80 m/min  | M        |
| INOX > 900 N/mm <sup>2</sup>   | 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 |
| <b>Services</b>        |   |
| Shank grinding Type HB | 129100 HB                                 |