

**Garant**
**GARANT Master INOX solid carbide slot drill HPC, TiAlN, Ø e8 DC: 20mm**

**Order data**

Order number	201647 20
GTIN	4062406113544
Item class	11X

**Description**
**Version:**

**Double** relief ground **2 chamfers hollow ground** for use in **HPC applications**.

Greater oxidation resistance and high-temperature hardness.

Can be used at high cutting speeds, particularly suitable even for Toolox®.

**Note:**

**Successor product to No. 201644.**

**Technical description**

Corner chamfer width at 45°	0.4 mm
Overall length L	104 mm
Feed $f_z$ for side milling in INOX < 900 N/mm <sup>2</sup>	0.13 mm
Shank Ø $D_s$	20 mm
Tolerance nominal Ø	e8
Feed $f_z$ for slot milling in stainless steel < 900 N/mm <sup>2</sup>	0.11 mm
Flute length $L_c$	38 mm
Helix angle	50 degrees
No. of teeth Z	2
Overhang length $L_1$ incl. recess	54 mm
Direction of infeed	horizontal, oblique and vertical

Shank	DIN 6535 HA to h6
Recess $\varnothing D_1$	19.7 mm
Cutting edge $\varnothing D_c$	20 mm
Corner chamfer angle	45 degrees
Series	Master INOX
Coating	TiAlN
Tool material	solid carbide
Standard	DIN 6527
Type	N
Cutting width $a_e$ for milling operation	Full slot cutting depth $1 \times D$
Cutting width $a_e$ for milling operation	Full slot cutting depth $1 \times D$
Through-coolant	no
Machining strategy	HPC
Colour ring	blue
Type of product	End / face mill

## User data

	Suitability	$V_c$	ISO code
Steel < 500 N/mm <sup>2</sup>	suitable	250 m/min	P
Steel < 750 N/mm <sup>2</sup>	suitable	230 m/min	P
Steel < 900 N/mm <sup>2</sup>	suitable	200 m/min	P
Steel < 1100 N/mm <sup>2</sup>	suitable	170 m/min	P
Steel < 1400 N/mm <sup>2</sup>	suitable	170 m/min	P
TOOLOX 33	suitable	115 m/min	H
TOOLOX 44	suitable	80 m/min	H
INOX < 900 N/mm <sup>2</sup>	suitable	110 m/min	M
INOX > 900 N/mm <sup>2</sup>	suitable	90 m/min	M
Uni	Suitable only under restricted conditions		

wet maximum	suitable
wet minimum	suitable only under restricted conditions
Air	suitable only under restricted conditions
<b>Services</b>	
Shank grinding Type HB	129100 HB