

Garant
Solid carbide slot drill DIN 6535 HA, TiAlN, Ø DC: 4,5mm

Order data

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|--------------|---------------|
| Order number | 202280 4,5 |
| GTIN | 4045197116338 |
| Item class | 11X |

Description
Version:
Eccentric relief ground.

 Dimensions similar to **DIN 6527 long series.**

 Tolerance: Size nominal Ø $D_c = e8$.

Technical description

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|--|----------------------------------|
| Recess Ø D_1 | 4.3 mm |
| Feed f_z for slot milling in steel < 900 N/mm ² | 0.02 mm |
| Overhang length L_1 incl. recess | 21 mm |
| No. of teeth Z | 3 |
| Corner chamfer width at 45° | 0.1 mm |
| Feed f_z for side milling in steel < 900 N/mm ² | 0.023 mm |
| Cutting edge Ø D_c | 4.5 mm |
| Shank Ø D_s | 6 mm |
| Overall length L | 57 mm |
| Flute length L_c | 13 mm |
| Direction of infeed | horizontal, oblique and vertical |
| Correction factor for v_c | 1.5 |
| Shank | DIN 6535 HA to h6 |

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|---|-----------------------------|
| Tolerance nominal \varnothing | e8 |
| Helix angle | 45 degrees |
| Corner chamfer angle | 45 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 |
| Steel < 55 HRC | suitable only under restricted conditions | 35 m/min | H |
| 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 | | |

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|------------------------|---|
| wet maximum | suitable |
| wet minimum | suitable only under restricted conditions |
| dry | suitable only under restricted conditions |
| Services | |
| Shank grinding Type HB | 129100 HB |