

Garant
GARANT Master Steel solid carbide slot drill, TiAlN, Ø DC: 1mm

Order data

Order number	201646 1
GTIN	4062406297824
Item class	11X

Description
Version:
Eccentric relief ground for stronger cutting edges.

Dimensions similar to DIN 6527.

Advantage:
Optimised flute geometry for improved chip evacuation.

Note:
Successor product to No. 201645.

Tolerance nominal Ø: f8

No. of teeth Z: 2

Helix angle: 38°

Direction of infeed: horizontal, oblique and vertical

Shank: DIN 6535 HA to h6

No. of teeth Z: 2

 Flute length L_c : 3 mm

 Overhang length L_1 incl. recess: 6 mm

 Recess Ø D_1 : 0.9 mm

Overall length L: 38 mm

 Shank Ø D_s : 3 mm

Technical description

Corner chamfer width at 45°	0.05 mm
Shank	DIN 6535 HA to h6
No. of teeth Z	2
Overall length L	38 mm

Recess $\varnothing D_1$	0.9 mm
Feed f_z for side milling in steel $< 750 \text{ N/mm}^2$	0.07 mm
Tolerance nominal \varnothing	f8
Shank $\varnothing D_s$	3 mm
Cutting edge $\varnothing D_c$	1 mm
Direction of infeed	horizontal, oblique and vertical
Flute length L_c	3 mm
Feed f_z for slot milling in steel $< 750 \text{ N/mm}^2$	0.005 mm
Helix angle	38°
Overhang length L_1 incl. recess	6 mm
Corner chamfer angle	90°
Series	Master Steel
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	$0.5 \times D$ for side milling
Through-coolant	no
Machining strategy	HPC
Colour ring	green
Type of product	End / face mill

User data

	Suitability	V_c	ISO code
Steel $< 500 \text{ N/mm}^2$	suitable	260 m/min	P
Steel $< 750 \text{ N/mm}^2$	suitable	240 m/min	P
Steel $< 900 \text{ N/mm}^2$	suitable	190 m/min	P
Steel $< 1100 \text{ N/mm}^2$	suitable	180 m/min	P

Steel < 1400 N/mm ²	suitable only under restricted conditions	150 m/min	P
INOX < 900 N/mm ²	suitable	80 m/min	M
INOX > 900 N/mm ²	suitable	70 m/min	M
GG(G)	suitable	250 m/min	K
Uni	suitable		
wet maximum	suitable		
wet minimum	suitable only under restricted conditions		
dry	suitable only under restricted conditions		
Air	suitable only under restricted conditions		