

**Garant**
**GARANT Master INOX solid carbide slot drill HPC, TiAlN, Ø e8 DC: 12mm**

**Order data**

Order number	201647 12
GTIN	4062406113520
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.**

Tolerance nominal Ø: e8

No. of teeth Z: 2

Helix angle: 50°

Direction of infeed: horizontal, oblique and vertical

Shank: DIN 6535 HA to h6

No. of teeth Z: 2

Flute length  $L_c$ : 26 mm

Overhang length  $L_1$  incl. recess: 38 mm

Recess Ø  $D_1$ : 11.8 mm

Overall length L: 83 mm

Shank Ø  $D_s$ : 12 mm

**Technical description**

Helix angle	50°
Shank	DIN 6535 HA to h6
Cutting edge Ø $D_c$	12 mm
Feed $f_z$ for slot milling in stainless steel < 900 N/mm <sup>2</sup>	0.07 mm

Corner chamfer width at 45°	0.25 mm
Overhang length $L_1$ incl. recess	38 mm
Direction of infeed	horizontal, oblique and vertical
Recess $\varnothing D_1$	11.8 mm
Flute length $L_c$	26 mm
Overall length $L$	83 mm
Shank $\varnothing D_s$	12 mm
Feed $f_z$ for side milling in INOX < 900 N/mm <sup>2</sup>	0.08 mm
No. of teeth $Z$	2
Tolerance nominal $\varnothing$	e8
Corner chamfer angle	45°
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×D
Cutting width $a_e$ for milling operation	Full slot cutting depth 1×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		

### Services

Shank clamping flats for shrink-fit chucks, with retainer function Shank Ø tool 12 mm	SZ2025 12
Shank recess Type FRST	209900 FRST
Shank grinding Type HB	129100 HB