

**Garant**
**GARANT Master Alu solid carbide slot drill HPC, uncoated, Ø e8 DC: 6Lmm**

**Order data**

Order number	201070 6L
GTIN	4062406186272
Item class	11Z

**Description**
**Version:**

**Precision balanced tools**, ideally suited for use on **high-speed spindles**. Special geometry for optimum chip evacuation thanks to **newly developed balancing process**.

Very smooth cutting action for **outstanding surface quality**.

**Technical description**

Helix angle	30 degrees
Recess Ø D <sub>1</sub>	5.5 mm
Balance quality with shank	G 1.8 with HA
No. of teeth Z	1
Shank Ø D <sub>s</sub>	6 mm
Shank	Plain shank
Tolerance nominal Ø	e8
Flute length L <sub>c</sub>	16 mm
Cutting edge Ø D <sub>c</sub>	6 mm
Direction of infeed	horizontal, oblique and vertical
Overhang length L <sub>1</sub> incl. recess	24 mm
Overall length L	50 mm
Feed f <sub>z</sub> for side milling in short-chipping aluminium	0.08 mm

Feed $f_z$ for slot milling in short-chipping aluminium	0.06 mm
Corner chamfer angle	90 degrees
Series	Master Alu
Coating	uncoated
Tool material	Solid carbide
Standard	Manufacturer's standard
Type	W
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	yellow
Type of product	End / face mill

## User data

	Suitability	$V_c$	ISO code
Alu plastics	suitable	180 m/min	N
Aluminium (short chipping)	suitable	140 m/min	N
Alu > 10% Si	Suitable	105 m/min	N
PMMA acrylic	Suitable	180 m/min	N
PE-HD	Suitable	130 m/min	N
PA 66	Suitable	150 m/min	N
PEEK	Suitable	130 m/min	N
PF 31	Suitable	110 m/min	N
Honeycomb sandwich	suitable only under restricted conditions	180 m/min	N
Cu	Suitable	140 m/min	N
CuZn	Suitable	180 m/min	N

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