

**Garant**
**GARANT Master Alu solid carbide slot drill HPC, uncoated, Ø e8 DC: 4Mmm**

**Order data**

Order number	201070 4M
GTIN	4062406186227
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**

Overhang length $L_1$ incl. recess	16 mm
Cutting edge $\varnothing D_c$	4 mm
No. of teeth Z	1
Shank $\varnothing D_s$	6 mm
Tolerance nominal $\varnothing$	e8
Direction of infeed	horizontal, oblique and vertical
Balance quality with shank	G 1.8 with HA
Flute length $L_c$	10 mm
Shank	Plain shank
Feed $f_z$ for side milling in short-chipping aluminium	0.06 mm
Feed $f_z$ for slot milling in short-chipping aluminium	0.04 mm
Helix angle	30 degrees
Recess $\varnothing D_1$	3.8 mm

Overall length L	50 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