

**Garant**
**GARANT Master Alu solid carbide slot drill HPC, DLC, Ø e8 DC: 8Emm**

**Order data**

Order number	201075 8E
GTIN	4062406186562
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**

No. of teeth Z	1
Flute length $L_c$	14 mm
Overall length L	60 mm
Feed $f_z$ for side milling in short-chipping aluminium	0.1 mm
Tolerance nominal $\varnothing$	e8
Recess $\varnothing D_1$	7.4 mm
Balance quality with shank	G 1.8 with HA
Direction of infeed	horizontal, oblique and vertical
Shank	Plain shank
Helix angle	30 degrees
Overhang length $L_1$ incl. recess	26 mm
Cutting edge $\varnothing D_c$	8 mm
Feed $f_z$ for slot milling in short-chipping aluminium	0.08 mm

Shank $\varnothing D_s$	8 mm
Corner chamfer angle	90 degrees
Series	Master Alu
Coating	DLC
Tool material	Solid carbide
Standard	Manufacturer's standard
Type	W
Cutting width $a_e$ for milling operation	Full slot cutting depth $1 \times D$
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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	480 m/min	N
Aluminium (short chipping)	suitable	440 m/min	N
Alu > 10% Si	suitable	400 m/min	N
PMMA acrylic	Suitable	200 m/min	N
PE-HD	Suitable	160 m/min	N
PA 66	Suitable	200 m/min	N
PEEK	Suitable	150 m/min	N
PF 31	Suitable	130 m/min	N
PVDF GF20	Suitable	180 m/min	N
POM GF25	Suitable	160 m/min	N
PA 66 GF30	Suitable	150 m/min	N
PEEK GF30	Suitable	130 m/min	N

PTFE CF25	Suitable	160 m/min	N
Honeycomb sandwich	suitable only under restricted conditions	300 m/min	N
Cu	Suitable	160 m/min	N
CuZn	Suitable	200 m/min	N
wet maximum	suitable		
wet minimum	suitable only under restricted conditions		
dry	suitable only under restricted conditions		
<b>Air Services</b>	Suitable		
Shank grinding Type HB			129100 HB