

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

**Order data**

Order number	201075 8K
GTIN	4062406186555
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>	7.4 mm
No. of teeth Z	1
Feed f <sub>z</sub> for side milling in short-chipping aluminium	0.1 mm
Shank	Plain shank
Tolerance nominal Ø	e8
Feed f <sub>z</sub> for slot milling in short-chipping aluminium	0.08 mm
Overhang length L <sub>1</sub> incl. recess	13 mm
Balance quality with shank	G 1.8 with HA
Flute length L <sub>c</sub>	8 mm
Shank Ø D <sub>s</sub>	8 mm
Direction of infeed	horizontal, oblique and vertical
Overall length L	50 mm

Cutting edge $\varnothing D_c$	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		
<del>Air</del> <b>Services</b>	Suitable		
Shank grinding Type HB			129100 HB