

Garant
GARANT Master Alu solid carbide slot drill HPC, DLC, Ø e8 DC: 85mm

Order data

Order number	201075 8S
GTIN	4062406186838
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

Recess Ø D ₁	7.4 mm
Cutting edge Ø D _c	8 mm
Flute length L _c	21 mm
Feed f _z for slot milling in short-chipping aluminium	0.08 mm
Helix angle	30 degrees
Overall length L	60 mm
Overhang length L ₁ incl. recess	31 mm
Shank	Plain shank
Feed f _z for side milling in short-chipping aluminium	0.1 mm
Balance quality with shank	G 1.8 with HA
Tolerance nominal Ø	e8
Shank Ø D _s	8 mm
No. of teeth Z	1

Direction of infeed	horizontal, oblique and vertical
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 $1 \times D$
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	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		
Air Services	Suitable		
Shank grinding Type HB			129100 HB