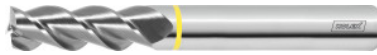



**Solid carbide slot drill, uncoated, Ø e8 DC: 4mm**

**Order data**

Order number	202242 4
GTIN	4045197767103
Item class	12X

**Description**
**Version:**

**Eccentric relief ground**, additionally **finish ground** in the flutes for **outstanding chip evacuation** in long-chipping aluminium workpieces.

**Application:**

For roughing and finishing.

**Technical description**

Tolerance nominal Ø	e8
Shank	DIN 6535 HA to h6
Cutting edge Ø D <sub>c</sub>	4 mm
Flute length L <sub>c</sub>	12 mm
No. of teeth Z	3
Feed f <sub>z</sub> for side milling in short-chipping aluminium	0.02 mm
Direction of infeed	horizontal, oblique and vertical
Overall length L	65 mm
Feed f <sub>z</sub> for slot milling in short-chipping aluminium	0.015 mm
Shank Ø D <sub>s</sub>	6 mm
Helix angle	45 degrees
Corner chamfer angle	90 degrees
Coating	uncoated

Tool material	Solid carbide
Standard	Manufacturer's standard
Type	W
Cutting width $a_e$ for milling operation	0.5×D for side milling
Cutting width $a_e$ for milling operation	Full slot cutting depth 1×D
Through-coolant	no
Colour ring	yellow
Type of product	End / face mill

### User data

	Suitability	$V_c$	ISO code
Aluminium	Suitable	170 m/min	N
Aluminium (short chipping)	suitable	140 m/min	N
Alu > 10% Si	suitable	105 m/min	N
PMMA acrylic	Suitable	160 m/min	N
PE-HD	Suitable	110 m/min	N
PA 66	Suitable	130 m/min	N
PEEK	Suitable	110 m/min	N
PF 31	Suitable	90 m/min	N
Honeycomb sandwich	suitable only under restricted conditions	160 m/min	N
Cu	Suitable	120 m/min	N
CuZn	Suitable	150 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

**Services**

Shank grinding Type HB

129100 HB