


**Solid carbide slot drill, uncoated, Ø e8 DC: 8mm**

**Order data**

Order number	202242 8
GTIN	4045197767134
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.

Through-coolant: no

Tolerance nominal Ø: e8

No. of teeth Z: 3

Helix angle: 45 °

Direction of infeed: horizontal, oblique and vertical

Shank: DIN 6535 HA to h6

No. of teeth Z: 3

Flute length  $L_c$ : 24 mm

Overall length L: 70 mm

Shank Ø  $D_s$ : 8 mm

Feed  $f_z$  for slot milling in short-chipping aluminium: 0.03 mm

Feed  $f_z$  for side milling in short-chipping aluminium: 0.04 mm

**Technical description**

Tolerance nominal Ø	e8
Shank	DIN 6535 HA to h6
Shank Ø $D_s$	8 mm
Direction of infeed	horizontal, oblique and vertical
Feed $f_z$ for slot milling in short-chipping aluminium	0.03 mm

Overall length L	70 mm
Cutting edge $\varnothing D_c$	8 mm
No. of teeth Z	3
Flute length $L_c$	24 mm
Feed $f_z$ for side milling in short-chipping aluminium	0.04 mm
Helix angle	45 °
Corner chamfer angle	90 °
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