

Garant
Solid carbide slot drill Left-hand flutes, uncoated, Ø e8 DC: 6mm

Order data

Order number	209322 6
GTIN	4045197507228
Item class	11X

Description
Version:

Special geometry for machining aluminium and plastics.
Left-hand flutes, right-hand cutting.

Application:

Extremely sharp cutting edges, **especially for machining plastics.**

Technical description

No. of teeth Z	2
Overhang length L_1 incl. recess	21 mm
Cutting edge $\varnothing D_c$	6 mm
Feed f_z for slot milling in PMMA	0.025 mm
Feed f_z for side milling in PMMA	0.03 mm
Recess $\varnothing D_1$	5.8 mm
Shank $\varnothing D_s$	6 mm
Overall length L	64 mm
Flute length L_c	16 mm
Direction of infeed	horizontal, oblique and vertical
Shank	DIN 6535 HA with h6
Tolerance nominal \varnothing	e8
Helix angle	20 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	0.5xD for side milling
Cutting width a_e for milling operation	Full slot cutting depth 1xD
Through-coolant	no
Colour ring	yellow
Type of product	End / face mill

User data

	Suitability	V_c	ISO code
Aluminium	suitable only under restricted conditions	180 m/min	N
Aluminium (short chipping)	suitable only under restricted conditions	140 m/min	N
Alu > 10% Si	suitable only under restricted conditions	105 m/min	N
PMMA acrylic	suitable	190 m/min	N
PE-HD	suitable	140 m/min	N
PA 66	suitable	160 m/min	N
PEEK	suitable	140 m/min	N
PF 31	suitable	120 m/min	N
Honeycomb sandwich	suitable only under restricted conditions	180 m/min	N
Cu	Suitable	150 m/min	N
CuZn	suitable only under restricted conditions	180 m/min	N
wet maximum	suitable		

dry	suitable only under restricted conditions
Air Services	suitable
Shank grinding Type HB	129100 HB