

Garant

Solid carbide slot drill Left-hand flutes, uncoated, Ø e8 DC: 20mm



Order data

Order number	209322 20
GTIN	4045197507273
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

Feed f_z for slot milling in PMMA	0.085 mm
Feed f_z for side milling in PMMA	0.12 mm
Recess Ø D_1	19.8 mm
Overhang length L_1 incl. recess	54 mm
No. of teeth Z	3
Cutting edge Ø D_c	20 mm
Shank Ø D_s	20 mm
Overall length L	104 mm
Flute length L_c	41 mm
Direction of infeed	horizontal, oblique and vertical
Shank	DIN 6535 HA with h6
Tolerance nominal Ø	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	0.5×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 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