

Garant
PCD slot drill with internal cooling dragging cut, PCD, Ø h10 DC: 4mm

Order data

Order number	209615 4
GTIN	4045197513250
Item class	11Y

Description
Version:

High performance PCD slot drill for the **highest demands in respect to material removal rates** when machining **GRP, CRP** and **graphite**. **Axial angle positive. $\alpha = 2^\circ$.**

Dragging cut for standard applications.

Through-coolant: yes

Tolerance nominal \varnothing : h10

No. of teeth Z: 2

Direction of infeed: horizontal, oblique and vertical

Shank: DIN 6535 HA with h6

No. of teeth Z: 2

Flute length L_c : 2.5 mm

Overhang length L_1 incl. recess: 15 mm

Recess $\varnothing D_1$: 3.8 mm

Overall length L: 60 mm

Shank $\varnothing D_s$: 6 mm

Technical description

Overhang length L_1 incl. recess	15 mm
Feed f_z for slot milling in graphite	0.07 mm
Feed f_z for slot milling in GRP CRP	0.01 mm
Cutting edge $\varnothing D_c$	4 mm
No. of teeth Z	2
Corner chamfer width at 45°	0.1 mm

Recess $\varnothing D_1$	3.8 mm
Shank $\varnothing D_s$	6 mm
Overall length L	60 mm
Flute length L_c	2.5 mm
Direction of infeed	horizontal, oblique and vertical
Shank	DIN 6535 HA with h6
Tolerance nominal \varnothing	h10
Corner chamfer angle	45 °
Coating	PCD
Tool material	PCD
Standard	Manufacturer's standard
Cutting width a_e for milling operation	Full slot cutting depth $1 \times D$
Through-coolant	yes
Colour ring	black
Type of product	End / face mill

User data

	Suitability	V_c	ISO code
Aluminium	suitable	2400 m/min	N
Aluminium (short chipping)	suitable	2000 m/min	N
Alu > 10% Si	suitable	1500 m/min	N
PMMA acrylic	suitable	1000 m/min	N
PE-HD	suitable	900 m/min	N
PA 66	suitable	900 m/min	N
PEEK	suitable	800 m/min	N
PVDF GF20	suitable	1200 m/min	N
POM GF25	suitable	1200 m/min	N
PA 66 GF30	suitable	1000 m/min	N

PEEK GF30	suitable	1000 m/min	N
PTFE CF25	suitable	1000 m/min	N
PEEK CF30	suitable	800 m/min	N
Hybrids	suitable		
MMC	suitable	400 m/min	N
GRP	suitable	500 m/min	N
CRP	suitable	500 m/min	N
wet maximum	suitable		
wet minimum	suitable		
dry	Suitable		
Air	suitable		

Services

Shank grinding Type HB

129100 HB