

**Garant**
**PCD slot drill with internal cooling dragging cut, PCD, Ø h10 DC: 6mm**

**Order data**

Order number	209615 6
GTIN	4045197478085
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  $L_c$ : 15 mm

Overhang length  $L_1$  incl. recess: 20 mm

Recess  $\varnothing D_1$ : 5.4 mm

Overall length L: 60 mm

Shank  $\varnothing D_s$ : 6 mm

**Technical description**

No. of teeth Z	2
Cutting edge $\varnothing D_c$	6 mm
Corner chamfer width at $45^\circ$	0.1 mm
Feed $f_z$ for slot milling in GRP CRP	0.03 mm
Feed $f_z$ for slot milling in graphite	0.1 mm
Overhang length $L_1$ incl. recess	20 mm

Recess $\varnothing D_1$	5.4 mm
Shank $\varnothing D_s$	6 mm
Overall length L	60 mm
Flute length $L_c$	15 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