

Garant
PCD slot drill with internal cooling straight cut, PCD, Ø h10 DC: 5mm

Order data

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|--------------|---------------|
| Order number | 209610 5 |
| GTIN | 4045197513212 |
| 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 0°.

Straight flutes for a neutral cut.

Through-coolant: yes

Tolerance nominal Ø: 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 : 3 mm

Overhang length L_1 incl. recess: 15 mm

Recess Ø D_1 : 4.6 mm

Overall length L: 60 mm

Shank Ø D_s : 6 mm

Technical description

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|---|---------|
| Recess Ø D_1 | 4.6 mm |
| Cutting edge Ø D_c | 5 mm |
| Feed f_z for slot milling in graphite | 0.09 mm |
| Overhang length L_1 incl. recess | 15 mm |
| No. of teeth Z | 2 |

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|---|--------------------------------------|
| Corner chamfer width at 45° | 0.1 mm |
| Feed f_z for slot milling in GRP CRP | 0.02 mm |
| Shank $\varnothing D_s$ | 6 mm |
| Overall length L | 60 mm |
| Flute length L_c | 3 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