

**Garant**
**PCD slot drill with internal cooling compacting cut, PCD, Ø h10 DC: 3mm**

**Order data**

Order number	209620 3
GTIN	4045197513274
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 negative.  $\alpha = -2^\circ$ .**

Compacting cut.

The material is pushed down on to the substrate. Highly suitable for thin materials.

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  $L_c$ : 2.5 mm

Overhang length  $L_1$  incl. recess: 15 mm

Recess Ø  $D_1$ : 2.8 mm

Overall length L: 60 mm

Shank Ø  $D_s$ : 6 mm

**Technical description**

Feed $f_z$ for slot milling in GRP CRP	0.01 mm
Cutting edge Ø $D_c$	3 mm
No. of teeth Z	2
Recess Ø $D_1$	2.8 mm
Overhang length $L_1$ incl. recess	15 mm
Corner chamfer width at $45^\circ$	0.1 mm

Feed $f_z$ for slot milling in graphite	0.05 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