

**Garant**
**Solid carbide slot drill, DLC, Ø e8 DC: 14mm**

**Order data**

Order number	201735 14
GTIN	4045197588456
Item class	11X

**Description**
**Version:**

With the latest generation of **DLC coating sp<sup>2</sup>**.  
Special geometry for machining aluminium and plastics.

**Application:**

Double relieved chip angle, **especially for aluminium machining.**

**Technical description**

Feed $f_z$ for side milling in cast aluminium	0.09 mm
Overhang length $L_1$ incl. recess	42 mm
Recess Ø $D_1$	13.8 mm
Feed $f_z$ for slot milling in cast aluminium	0.05 mm
Cutting edge Ø $D_c$	14 mm
No. of teeth $Z$	3
Shank Ø $D_s$	14 mm
Overall length $L$	83 mm
Flute length $L_c$	30 mm
Direction of infeed	horizontal, oblique and vertical
Shank	DIN 6535 HA to h6
Tolerance nominal Ø	e8
Helix angle	20 degrees

Corner chamfer angle	90 degrees
Coating	DLC
Tool material	Solid carbide
Standard	Manufacturer's standard
Type	W
Cutting width $a_e$ for milling operation	0,25×D ved beskæring
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	480 m/min	N
Aluminium (short chipping)	suitable	440 m/min	N
Alu > 10% Si	suitable	400 m/min	N
PMMA acrylic	Suitable	200 m/min	N
PE-HD	Suitable	160 m/min	N
PA 66	Suitable	200 m/min	N
PEEK	Suitable	150 m/min	N
PF 31	Suitable	130 m/min	N
PVDF GF20	suitable	180 m/min	N
POM GF25	Suitable	160 m/min	N
PA 66 GF30	suitable	150 m/min	N
PEEK GF30	suitable	130 m/min	N
PTFE CF25	suitable	160 m/min	N
Honeycomb sandwich	suitable only under restricted conditions	300 m/min	N

Cu	Suitable	160 m/min	N
CuZn	Suitable	200 m/min	N
wet maximum	suitable		
wet minimum	suitable		
dry	suitable only under restricted conditions		
Air	suitable		