

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

**Order data**

|              |               |
|--------------|---------------|
| Order number | 209800 6      |
| GTIN         | 4062406765095 |
| Item class   | 100           |

**Description**
**Version:**
**High performance PCD slot drill for high metal removal rates.**
**Axial angle 0°.**

Straight flutes for a neutral cut.

**Technical description**

|   |                                  |
|---|----------------------------------|
| Overhang length $L_1$ incl. recess            | 20 mm                            |
| Feed $f_z$ for side milling in graphite       | 0.1 mm                           |
| Corner chamfer width at 45°                   | 0.1 mm                           |
| Shank $\varnothing D_s$                       | 6 mm                             |
| Direction of infeed                           | horizontal, oblique and vertical |
| Feed $f_z$ for side milling in cast aluminium | 0.04 mm                          |
| Recess $\varnothing D_1$                      | 5.4 mm                           |
| Feed $f_z$ for slot milling in cast aluminium | 0.03 mm                          |
| Cutting edge $\varnothing D_c$                | 6 mm                             |
| Flute length $L_c$                            | 15 mm                            |
| Overall length $L$                            | 60 mm                            |
| Tolerance nominal $\varnothing$               | h10                              |
| No. of teeth $Z$                              | 2                                |

|   |                                      |
|---|--------------------------------------|
| Shank                                     | DIN 6535 HA with h6                  |
| Feed $f_z$ for slot milling in graphite   | 0.1 mm                               |
| Corner chamfer angle                      | 45 degrees                           |
| Coating                                   | PCD                                  |
| Tool material                             | PCD                                  |
| Standard                                  | Manufacturer's standard              |
| Cutting width $a_e$ for milling operation | Full slot cutting depth $1 \times D$ |
| Cutting width $a_e$ for milling operation | $0.2 \times D$ for side milling      |
| 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