

**Garant**
**PCD slot drill with internal cooling straight cut, PCD, Ø h10 DC: 12mm**

**Order data**

Order number	209800 12
GTIN	4062406765125
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**

Feed $f_z$ for slot milling in cast aluminium	0.08 mm
No. of teeth Z	2
Shank $\varnothing D_s$	12 mm
Flute length $L_c$	20 mm
Recess $\varnothing D_1$	11 mm
Direction of infeed	horizontal, oblique and vertical
Shank	DIN 6535 HA with h6
Feed $f_z$ for side milling in graphite	0.14 mm
Overall length L	100 mm
Feed $f_z$ for slot milling in graphite	0.14 mm
Corner chamfer angle	45 degrees
Feed $f_z$ for side milling in cast aluminium	0.09 mm
Overhang length $L_1$ incl. recess	30 mm

Cutting edge $\varnothing D_c$	12 mm
Tolerance nominal $\varnothing$	h10
Corner chamfer width at 45°	0.1 mm
Coating	PCD
Tool material	PCD
Standard	Manufacturer's standard
Cutting width $a_e$ for milling operation	Full slot cutting depth 1xD
Cutting width $a_e$ for milling operation	0.2xD 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