

**Garant**
**PCD slot drill with internal cooling dragging cut, PCD, Ø h10 DC: 4mm**

**Order data**

Order number	209801 4
GTIN	4062406765156
Item class	100

**Description**
**Version:**

**High performance PCD slot drill for high metal removal rates. Axial angle positive.  $\alpha = 2^\circ$ .**  
 Dragging cut for standard applications.

**Technical description**

Feed $f_z$ for side milling in graphite	0.07 mm
Cutting edge $\varnothing D_c$	4 mm
Feed $f_z$ for slot milling in graphite	0.07 mm
Direction of infeed	horizontal, oblique and vertical
Overall length L	60 mm
No. of teeth Z	2
Feed $f_z$ for side milling in cast aluminium	0.02 mm
Feed $f_z$ for slot milling in cast aluminium	0.01 mm
Shank $\varnothing D_s$	6 mm
Overhang length $L_1$ incl. recess	15 mm
Corner chamfer width at $45^\circ$	0.1 mm
Tolerance nominal $\varnothing$	h10
Shank	DIN 6535 HA with h6
Flute length $L_c$	2.5 mm

Corner chamfer angle	45 degrees
Recess $\varnothing D_1$	3.8 mm
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		
<b>Services</b>			

Shank grinding Type HB	129100 HB
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