

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

Order data

Order number	209802 6
GTIN	4062406765255
Item class	100

Description
Version:

High performance PCD slot drill for **high metal removal rates. Axial angle negative. $\alpha = -2^\circ$.**
Compacting cut.

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

Technical description

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
Feed f_z for slot milling in graphite	0.1 mm
Overhang length L_1 incl. recess	20 mm
Tolerance nominal \varnothing	h10
Corner chamfer angle	45 degrees
No. of teeth Z	2
Shank $\varnothing D_s$	6 mm
Feed f_z for side milling in cast aluminium	0.04 mm
Flute length L_c	15 mm
Corner chamfer width at 45°	0.1 mm
Direction of infeed	horizontal, oblique and vertical

Shank	DIN 6535 HA with h6
Feed f_z for side milling in graphite	0.1 mm
Overall length L	60 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		

Services

Shank grinding Type HB

129100 HB