

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

**Order data**

Order number	209802 4
GTIN	4062406765231
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**

Tolerance nominal $\varnothing$	h10
Overall length L	60 mm
Corner chamfer angle	45 degrees
Feed $f_z$ for side milling in graphite	0.07 mm
Overhang length $L_1$ incl. recess	15 mm
Direction of infeed	horizontal, oblique and vertical
Flute length $L_c$	2.5 mm
Cutting edge $\varnothing D_c$	4 mm
Corner chamfer width at $45^\circ$	0.1 mm
Shank	DIN 6535 HA with h6
No. of teeth Z	2
Recess $\varnothing D_1$	3.8 mm
Feed $f_z$ for slot milling in graphite	0.07 mm

Feed $f_z$ for side milling in cast aluminium	0.02 mm
Shank $\varnothing D_s$	6 mm
Feed $f_z$ for slot milling in cast aluminium	0.01 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