

Garant
PCD ball nose slot drill with internal cooling straight cut, PCD, Ø e8 DC: 4mm

Order data

Order number	209806 4
GTIN	4062406765415
Item class	100

Description
Version:

High-performance PCD slot drill for the **highest demands in respect to material removal rates. Straight flutes** for a neutral cut.

Technical description

No. of teeth Z	2
Feed f_z for copy milling in graphite	0.1 mm
Flute length L_c	2.5 mm
Feed f_z for copy milling in cast aluminium	0.05 mm
Overall length L	60 mm
Shank $\varnothing D_s$	6 mm
Feed f_z for side milling in graphite	0.06 mm
Overhang length L_1 incl. recess	15 mm
Cutting edge $\varnothing D_c$	4 mm
Feed f_z for side milling in cast aluminium	0.03 mm
Recess $\varnothing D_1$	3.8 mm
Radius R	2 mm
Coating	PCD
Tool material	PCD

Standard	Manufacturer's standard
Tolerance nominal \varnothing	e8
Direction of infeed	horizontal, oblique and vertical
Cutting width a_e for milling operation	0.05×D for copy milling
Cutting width a_e for milling operation	0.2×D for side milling
Shank	DIN 6535 HA to h6
Through-coolant	yes
Colour ring	black
Type of product	Ball-nosed slot drill

User data

	Suitability	V_c	ISO code
Alu plastics	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		