

**Garant**
**Solid carbide slot drill, uncoated, Ø h10 DC: 1,5mm**

**Order data**

Order number	209300 1,5
GTIN	4045197854711
Item class	11X

**Description**
**Version:**

Special geometry **for machining plastic.**

**Large flutes for unobstructed swarf evacuation.**

**Application:**

Especially for milling **plastics, plunging** and **contour milling.**

**Note:**

**Successor product to No. 209310.**

**Technical description**

Feed $f_z$ for slot milling in PMMA	0.004 mm
No. of teeth Z	1
Shank $\varnothing D_s$	3 mm
Cutting edge $\varnothing D_c$	1.5 mm
Recess $\varnothing D_1$	1.3 mm
Overall length L	50 mm
Flute length $L_c$	6 mm
Overhang length $L_1$ incl. recess	10 mm
Tolerance nominal $\varnothing$	h10
Direction of infeed	horizontal, oblique and vertical
Shank	DIN 6535 HA to h5

Helix angle	23 degrees
Corner chamfer angle	90 degrees
Coating	uncoated
Tool material	Solid carbide
Standard	Manufacturer's standard
Type	W
Cutting width $a_e$ for milling operation	Full slot cutting depth $1 \times D$
Through-coolant	no
Colour ring	yellow
Type of product	End / face mill

## User data

	Suitability	$V_c$	ISO code
Aluminium	suitable only under restricted conditions	180 m/min	N
Aluminium (short chipping)	suitable only under restricted conditions	140 m/min	N
Alu > 10% Si	suitable only under restricted conditions	105 m/min	N
PMMA acrylic	suitable	190 m/min	N
PE-HD	suitable	140 m/min	N
PA 66	suitable	160 m/min	N
PEEK	suitable	140 m/min	N
PF 31	suitable	120 m/min	N
Honeycomb sandwich	suitable only under restricted conditions	180 m/min	N
Cu	Suitable	150 m/min	N
CuZn	suitable only under restricted conditions	180 m/min	N
wet maximum	suitable		

dry	suitable only under restricted conditions
Air	suitable