

**Garant**
**Solid carbide slot drill Left-hand flutes, uncoated, Ø h10 DC: 1,5mm**

**Order data**

Order number	209305 1,5
GTIN	4045197854728
Item class	11X

**Description**
**Version:**

Special geometry **for machining plastic.**

**Large flutes for unobstructed swarf evacuation.**

Left-hand flutes, right-hand cutting.

**Application:**

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

**Note:**

**Successor product to No. 209315.**

**Technical description**

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

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