

Garant
Solid carbide slot drill Left-hand flutes, uncoated, Ø h10 DC: 4mm

Order data

| | |
|--------------|---------------|
| Order number | 209305 4 |
| GTIN | 4045197859457 |
| 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

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|-------------------------------------|----------------------------------|
| Overhang length L_1 incl. recess | 20 mm |
| Cutting edge $\varnothing D_c$ | 4 mm |
| Shank $\varnothing D_s$ | 4 mm |
| Flute length L_c | 15 mm |
| Overall length L | 60 mm |
| Shank | DIN 6535 HA to h5 |
| Feed f_z for slot milling in PMMA | 0.015 mm |
| Recess $\varnothing D_1$ | 3.8 mm |
| Tolerance nominal \varnothing | h10 |
| Direction of infeed | horizontal, oblique and vertical |
| No. of teeth Z | 1 |

| | |
|---|--------------------------------------|
| 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 | | |

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|-----|---|
| dry | suitable only under restricted conditions |
| Air | suitable |