

**Garant**
**Solid carbide slot drill Left-hand flutes, uncoated, Ø h10 DC: 6mm**

**Order data**

Order number	209305 6
GTIN	4045197859471
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**

Overall length L	65 mm
Direction of infeed	horizontal, oblique and vertical
Flute length L <sub>c</sub>	20 mm
Overhang length L <sub>1</sub> incl. recess	25 mm
Tolerance nominal Ø	h10
No. of teeth Z	1
Feed f <sub>z</sub> for slot milling in PMMA	0.025 mm
Shank Ø D <sub>s</sub>	6 mm
Recess Ø D <sub>1</sub>	5.8 mm
Cutting edge Ø D <sub>c</sub>	6 mm
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