

**Garant**
**Solid carbide slot drill Left-hand flutes, uncoated,  $\varnothing$  h10 DC: 12mm**


## Order data

Order number	209305 12
GTIN	4045197859501
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

No. of teeth Z	1
Overhang length $L_1$ incl. recess	38 mm
Flute length $L_c$	30 mm
Shank	DIN 6535 HA to h5
Feed $f_z$ for slot milling in PMMA	0.05 mm
Overall length L	83 mm
Cutting edge $\varnothing D_c$	12 mm
Shank $\varnothing D_s$	12 mm
Direction of infeed	horizontal, oblique and vertical
Recess $\varnothing D_1$	11.8 mm
Tolerance nominal $\varnothing$	h10

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