

**Garant**
**Solid carbide slot drill DIN 6535 HA, DLC, Ø DC: 4mm**

**Order data**

Order number	201270 4
GTIN	4045197586056
Item class	11X

**Description**
**Version:**

Stronger cutting edges.

Dimensions similar to DIN 6527.

With the latest generation of **DLC coating sp<sup>2</sup>**.

**Technical description**

Cutting edge Ø D <sub>c</sub>	4 mm
Overhang length L <sub>1</sub> incl. recess	18 mm
Feed f <sub>z</sub> for side milling in short-chipping aluminium	0.02 mm
Feed f <sub>z</sub> for slot milling in short-chipping aluminium	0.015 mm
Recess Ø D <sub>1</sub>	3.9 mm
No. of teeth Z	2
Corner chamfer width at 45°	0.1 mm
Shank Ø D <sub>s</sub>	6 mm
Overall length L	57 mm
Flute length L <sub>c</sub>	11 mm
Direction of infeed	horizontal, oblique and vertical
Shank	DIN 6535 HA to h6
Tolerance nominal Ø	e8

Helix angle	45 degrees
Corner chamfer angle	45 degrees
Coating	DLC
Tool material	Solid carbide
Standard	DIN 6527
Type	W
Cutting width $a_e$ for milling operation	0.5×D for side milling
Cutting width $a_e$ for milling operation	Full slot cutting depth 1×D
Through-coolant	no
Colour ring	yellow
Type of product	End / face mill

## User data

	Suitability	$V_c$	ISO code
Aluminium	Suitable	480 m/min	N
Aluminium (short chipping)	suitable	440 m/min	N
Alu > 10% Si	suitable	400 m/min	N
PMMA acrylic	Suitable	200 m/min	N
PE-HD	Suitable	160 m/min	N
PA 66	Suitable	200 m/min	N
PEEK	Suitable	150 m/min	N
PF 31	Suitable	130 m/min	N
PVDF GF20	suitable	180 m/min	N
POM GF25	suitable	160 m/min	N
PA 66 GF30	suitable	150 m/min	N
PEEK GF30	suitable	130 m/min	N
PTFE CF25	suitable	160 m/min	N

Honeycomb sandwich	suitable only under restricted conditions	300 m/min	N
Cu	Suitable	160 m/min	N
CuZn	Suitable	200 m/min	N
wet maximum	suitable		
wet minimum	suitable		
dry	suitable only under restricted conditions		
<del>Air</del> <b>Services</b>	suitable		
Shank grinding Type HB		129100 HB	