


**Solid carbide slot drill DIN 6535 HB, uncoated, Ø DC: 14mm**

**Order data**

Order number	201280 14
GTIN	4045197112521
Item class	12X

**Description**
**Version:**

Stronger cutting edges.

Dimensions similar to DIN 6527.

**Technical description**

Feed $f_z$ for slot milling in short-chipping aluminium	0.05 mm
No. of teeth Z	2
Feed $f_z$ for side milling in short-chipping aluminium	0.07 mm
Cutting edge Ø $D_c$	14 mm
Corner chamfer width at 45°	0.1 mm
Shank Ø $D_s$	14 mm
Overall length L	83 mm
Flute length $L_c$	26 mm
Direction of infeed	horizontal, oblique and vertical
Shank	DIN 6535 HB to h6
Tolerance nominal Ø	h10
Helix angle	45 degrees
Corner chamfer angle	45 degrees
Coating	uncoated

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	180 m/min	N
Aluminium (short chipping)	suitable	140 m/min	N
Alu > 10% Si	suitable	105 m/min	N
PMMA acrylic	Suitable	180 m/min	N
PE-HD	Suitable	130 m/min	N
PA 66	Suitable	150 m/min	N
PEEK	Suitable	130 m/min	N
PF 31	Suitable	110 m/min	N
Honeycomb sandwich	suitable only under restricted conditions	180 m/min	N
Cu	Suitable	140 m/min	N
CuZn	Suitable	180 m/min	N
wet maximum	suitable		
wet minimum	suitable		
dry	suitable only under restricted conditions		
Air	suitable		

