

**Garant**
**Solid carbide slot drill, uncoated, Ø e8 DC: 4mm**

**Order data**

Order number	209320 4
GTIN	4045197478702
Item class	11X

**Description**
**Version:**

Special geometry for machining aluminium and plastics.

**Application:**

Extremely sharp cutting edges, **especially for machining plastics.**

**Technical description**

No. of teeth Z	2
Feed $f_z$ for slot milling in PMMA	0.015 mm
Cutting edge $\varnothing D_c$	4 mm
Overhang length $L_1$ incl. recess	16 mm
Recess $\varnothing D_1$	3.8 mm
Feed $f_z$ for side milling in PMMA	0.02 mm
Shank $\varnothing D_s$	4 mm
Overall length L	54 mm
Flute length $L_c$	13 mm
Direction of infeed	horizontal, oblique and vertical
Shank	DIN 6535 HA with h6
Tolerance nominal $\varnothing$	e8
Helix angle	20 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	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 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