

Garant
Solid carbide slot drill Left-hand flutes, uncoated, Ø h10 DC: 8mm


Order data

Order number	209305 8
GTIN	4045197859488
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

Tolerance nominal Ø	h10
Shank	DIN 6535 HA to h5
No. of teeth Z	1
Direction of infeed	horizontal, oblique and vertical
Flute length L_c	22 mm
Feed f_z for slot milling in PMMA	0.03 mm
Recess Ø D_1	7.8 mm
Overall length L	70 mm
Shank Ø D_s	8 mm
Cutting edge Ø D_c	8 mm
Overhang length L_1 incl. recess	27 mm

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