


**Solid carbide slot drill, uncoated, Ø e8 DC: 3mm**

**Order data**

|              |               |
|--------------|---------------|
| Order number | 202242 3      |
| GTIN         | 4045197767097 |
| Item class   | 12X           |

**Description**
**Version:**

**Eccentric relief ground**, additionally **finish ground** in the flutes for **outstanding chip evacuation** in long-chipping aluminium workpieces.

**Application:**

For roughing and finishing.

Through-coolant: no

Tolerance nominal Ø: e8

No. of teeth Z: 3

Helix angle: 45 °

Direction of infeed: horizontal, oblique and vertical

Shank: DIN 6535 HA to h6

No. of teeth Z: 3

Flute length  $L_c$ : 9 mm

Overall length L: 65 mm

Shank Ø  $D_s$ : 6 mm

Feed  $f_z$  for slot milling in short-chipping aluminium: 0.008 mm

Feed  $f_z$  for side milling in short-chipping aluminium: 0.01 mm

**Technical description**

|   |          |
|---|----------|
| Tolerance nominal Ø                                     | e8       |
| Feed $f_z$ for slot milling in short-chipping aluminium | 0.008 mm |
| Overall length L  | 65 mm    |
| Flute length $L_c$                                      | 9 mm     |
| No. of teeth Z  | 3        |

|   |                                  |
|---|----------------------------------|
| Feed $f_z$ for side milling in short-chipping aluminium | 0.01 mm                          |
| Direction of infeed                                     | horizontal, oblique and vertical |
| Shank   | DIN 6535 HA to h6                |
| Shank $\varnothing D_s$                                 | 6 mm                             |
| Cutting edge $\varnothing D_c$                          | 3 mm                             |
| Helix angle   | 45 °                             |
| Corner chamfer angle                                    | 90 °                             |
| 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    | 170 m/min | N        |
| Aluminium (short chipping) | suitable    | 140 m/min | N        |
| Alu > 10% Si               | suitable    | 105 m/min | N        |
| PMMA acrylic               | Suitable    | 160 m/min | N        |
| PE-HD                      | Suitable    | 110 m/min | N        |
| PA 66                      | Suitable    | 130 m/min | N        |
| PEEK                       | Suitable    | 110 m/min | N        |
| PF 31                      | Suitable    | 90 m/min  | N        |

|                    |   |           |   |
|--------------------|---|-----------|---|
| Honeycomb sandwich | suitable only under restricted conditions | 160 m/min | N |
| Cu                 | Suitable                                  | 120 m/min | N |
| CuZn               | Suitable                                  | 150 m/min | N |
| wet maximum        | suitable                                  |           |   |
| wet minimum        | suitable only under restricted conditions |           |   |
| dry                | Suitable only under restricted conditions |           |   |
| Air                | suitable only under restricted conditions |           |   |

**Services**

Shank grinding Type HB

129100 HB