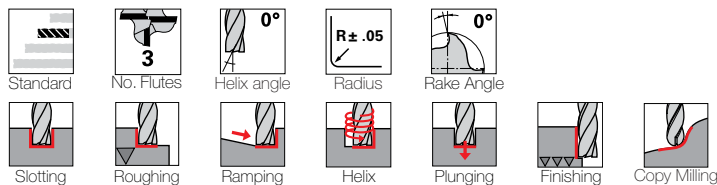


PCD Slot Drills (3-flute) - Metric - Standard Length - Coolant Fed



for aluminum and composites



Tool material

PCD

Surface finish

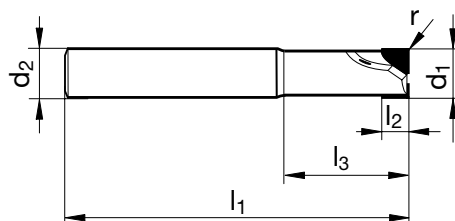
bright

Series

5495

| Application group | Material examples | Ideal for |
|-------------------|-------------------|-----------|
| P | Steel | — |
| M | Stainless steel | — |
| K | Cast iron | — |
| N | Aluminum | ● |
| S | Ni / Ti alloys | — |
| H | Hardened steel | — |
| | Composites | ● |

●=Optimal ○=Secondary



Speed and Feed data found on page 132

| d1 | tol. d1 | d2 h6 | l1 | l2 | l3 | r | No. of Flutes | Code no. | EDP Number |
|--------|---------|--------|--------|-------|-------|------|---------------|----------|---------------|
| mm | mm | mm | mm | mm | mm | mm | | | |
| 14.000 | ± 0,02 | 14.000 | 83.00 | 8.00 | 38.00 | 0.10 | 3 | 14.000 | 9054950140000 |
| 14.000 | ± 0,02 | 14.000 | 83.00 | 16.00 | 38.00 | 0.10 | 3 | 14.001 | 9054950140010 |
| 16.000 | ± 0,02 | 16.000 | 100.00 | 12.00 | 52.00 | 0.10 | 3 | 16.000 | 9054950160000 |
| 16.000 | ± 0,02 | 16.000 | 100.00 | 20.00 | 52.00 | 0.10 | 3 | 16.001 | 9054950160010 |
| 18.000 | ± 0,02 | 18.000 | 100.00 | 12.00 | 52.00 | 0.10 | 3 | 18.000 | 9054950180000 |
| 18.000 | ± 0,02 | 18.000 | 100.00 | 20.00 | 52.00 | 0.10 | 3 | 18.001 | 9054950180010 |
| 20.000 | ± 0,02 | 20.000 | 100.00 | 12.00 | 50.00 | 0.10 | 3 | 20.000 | 9054950200000 |
| 20.000 | ± 0,02 | 20.000 | 100.00 | 20.00 | 50.00 | 0.10 | 3 | 20.001 | 9054950200010 |

Cutting values: Slotting*, HPC-roughing and copy milling

| Type | Characteristic | Feed depth a_p | Feed width** a_e | Cutting speed v_c | fz (mm/z) with nom. Ø | | | | | | |
|----------------|------------------------|---------------------|-----------------------|------------------------|-----------------------|------|------|------|------|------|------|
| | | | | | 4 | 6 | 8 | 10 | 12 | 16 | 20 |
| N Aluminium | up to 7% Si | — | — | — | — | — | — | — | — | — | — |
| | up to 17% Si | 0.5xd | 1xd | 220 | 0.02 | 0.03 | 0.04 | 0.05 | 0.06 | 0.07 | 0.09 |
| Graphite | up to 8 µm grain size | 1.5xd | 1xd | 350 | 0.04 | 0.06 | 0.08 | 0.1 | 0.12 | 0.15 | 0.18 |
| Composites | over 50% fiber content | 1xd | 1xd | 200 | 0.015 | 0.03 | 0.04 | 0.05 | 0.06 | 0.08 | 0.09 |

* peripheral cooling "Guhrojet" is recommended for optimal chip evacuation and tool life, for graphite and Kevlar-machining air cooling

** at lower feed width the cutting speed v_c and feed rate f_z can be increased by 30%