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

for aluminum and composites


Standard

No. Flutes

Radius

Rake Angle


Slotting


Roughing


Ramping


Helix


Finishing

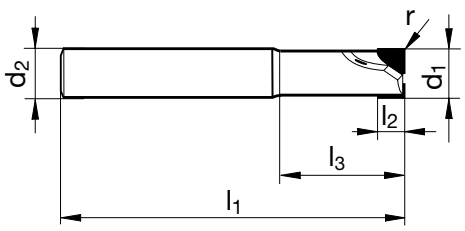

Copy Milling

Tool material	**PCD**
Surface finish	bright
Series	**5496**

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 mm	tol. d1 mm	d2 h6 mm	l1 mm	l2 mm	l3 mm	r mm	No. of Flutes	Code no.	EDP Number
14.000	± 0,02	14.000	100.00	8.00	38.00	0.10	3	14.000	**9054960140000**
14.000	± 0,02	14.000	100.00	16.00	38.00	0.10	3	14.001	**9054960140010**
16.000	± 0,02	16.000	150.00	12.00	52.00	0.10	3	16.000	**9054960160000**
16.000	± 0,02	16.000	150.00	20.00	52.00	0.10	3	16.001	**9054960160010**
18.000	± 0,02	18.000	150.00	12.00	52.00	0.10	3	18.000	**9054960180000**
18.000	± 0,02	18.000	150.00	20.00	52.00	0.10	3	18.001	**9054960180010**
20.000	± 0,02	20.000	150.00	12.00	50.00	0.10	3	20.000	**9054960200000**
20.000	± 0,02	20.000	150.00	20.00	50.00	0.10	3	20.001	**9054960200010**

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 vc and feed rate fz can be increased by 30%