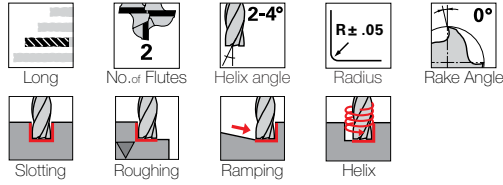


PCD Slot Drills (2-flute) - Metric - Long Length - Coolant Fed



for aluminum and composites



Tool material
Surface finish

PCD

bright

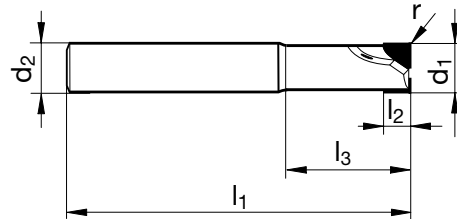
Series

5493

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			
4.000	± 0,02	6.000	70.00	6.00	6.40	0.10	2	4.000	9054930040000
5.000	± 0,02	6.000	70.00	8.00	8.40	0.10	2	5.000	9054930050000
6.000	± 0,02	6.000	75.00	8.00	21.00	0.10	2	6.000	9054930060000
8.000	± 0,02	8.000	100.00	8.00	27.00	0.10	2	8.000	9054930080000
8.000	± 0,02	8.000	100.00	12.00	27.00	0.10	2	8.001	9054930080010
10.000	± 0,02	10.000	100.00	8.00	32.00	0.10	2	10.000	9054930100000
10.000	± 0,02	10.000	100.00	16.00	32.00	0.10	2	10.001	9054930100010
12.000	± 0,02	12.000	100.00	8.00	38.00	0.10	2	12.000	9054930120000
12.000	± 0,02	12.000	100.00	16.00	38.00	0.10	2	12.001	9054930120010
14.000	± 0,02	14.000	100.00	8.00	38.00	0.10	2	14.000	9054930140000
14.000	± 0,02	14.000	100.00	16.00	38.00	0.10	2	14.001	9054930140010
16.000	± 0,02	16.000	150.00	12.00	52.00	0.10	2	16.000	9054930160000
16.000	± 0,02	16.000	150.00	20.00	52.00	0.10	2	16.001	9054930160010
18.000	± 0,02	18.000	125.00	12.00	52.00	0.10	2	18.000	9054930180000
18.000	± 0,02	18.000	125.00	20.00	52.00	0.10	2	18.001	9054930180010
18.000	± 0,02	18.000	150.00	20.00	52.00	0.10	2	18.002	9054930180020
18.000	± 0,02	18.000	150.00	12.00	52.00	0.10	2	18.003	9054930180030
20.000	± 0,02	20.000	150.00	12.00	50.00	0.10	2	20.000	9054930200000
20.000	± 0,02	20.000	150.00	20.00	50.00	0.10	2	20.001	9054930200010

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 fz can be increased by 30%