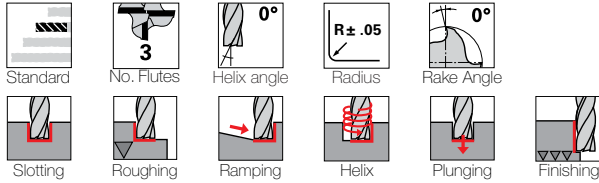


PCD Slot Drills (3-flute) - Inch - Standard Length

for aluminum and composites



Tool material

PCD

Surface finish

Bright

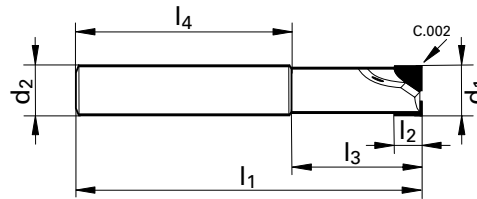
Series

3870

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 e10	d2 h6	l1	l2	l3	l4	No. of Flutes	Code no.	EDP Number
inch	inch	inch	inch	inch	inch			
1/2	1/2	3	1/2	1 5/16	1 11/16	3	12.700	9038700127000
3/4	3/4	3	1/2	1	2	3	19.050	9038700190500
1	1	4	1	1 5/8	2 3/8	3	25.400	9038700254000

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

ISO Code	Hardness	Cutting Speed SFM	Feed Inch Per Tooth (IPT) with nom. Dia				
			1/4	3/8	1/2	3/4	1
N Aluminium	less than 7% Si	1970	0.0015	0.0023	0.0029	0.0038	0.0040
	Up to 17% Si	850	0.0013	0.0019	0.0025	0.0034	0.0036
Graphite	up to 8 micron grain size	1475	0.0025	0.0038	0.0050	0.0068	0.0072
Composites	over 50% fiber content	980	0.0013	0.0019	0.0025	0.0034	0.0036

* 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%