

**Garant**
**Solid carbide milling cutter Composite, dragging cut, Diamond, Ø h10 DC: 4mm**

**Order data**

Order number	209546 4
GTIN	4062406362270
Item class	100

**Description**
**Version:**

**Tool cutting edge has been specifically developed further** for optimal machining of composite materials.

Overall length similar to **DIN 6527 long**.

Right-hand helix, **dragging cut** for standard applications.

**Technical description**

Cutting edge Ø D <sub>c</sub>	4 mm
Shank Ø D <sub>s</sub>	6 mm
Direction of infeed	horizontal, oblique and vertical
Shank	DIN 6535 HA to h6
Corner chamfer angle	45 degrees
Recess Ø D <sub>1</sub>	3.9 mm
No. of teeth Z	8
Flute length L <sub>c</sub>	11 mm
Corner chamfer width at 45°	0.08 mm
Feed f <sub>z</sub> for slot milling in GRP CRP	0.021 mm
Helix angle	8 degrees
Overhang length L <sub>1</sub> incl. recess	19 mm

Tolerance nominal $\varnothing$	h10
Overall length L	57 mm
Coating	Diamond
Tool material	Solid carbide
Standard	DIN 6527
Cutting width $a_e$ for milling operation	Full slot cutting depth $1 \times D$
Through-coolant	no
Colour ring	black
Type of product	End / face mill

### User data

	Suitability	$V_c$	ISO code
PVDF GF20	suitable	100 m/min	N
POM GF25	suitable	100 m/min	N
PA 66 GF30	suitable	100 m/min	N
PEEK GF30	suitable	100 m/min	N
PTFE CF25	suitable	100 m/min	N
PEEK CF30	suitable	100 m/min	N
Hybrids	suitable		
Honeycomb sandwich	suitable	195 m/min	N
CRP	suitable	145 m/min	N
GRP, CRP	suitable	145 m/min	N
Graphite	suitable	200 m/min	N
wet maximum	suitable		
dry	suitable		
Air	suitable		