

Garant
Solid carbide milling cutter Composite, dragging cut, Diamond, Ø h10 DC: 20mm

Order data

Order number	209546 20
GTIN	4062406362362
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

Overhang length L_1 incl. recess	52 mm
Cutting edge $\varnothing D_c$	20 mm
Corner chamfer width at 45°	0.4 mm
Shank $\varnothing D_s$	20 mm
Overall length L	104 mm
Flute length L_c	38 mm
No. of teeth Z	8
Direction of infeed	horizontal, oblique and vertical
Feed f_z for slot milling in GRP CRP	0.043 mm
Recess $\varnothing D_1$	19.4 mm
Corner chamfer angle	45 degrees
Tolerance nominal \varnothing	h10

Shank	DIN 6535 HA to h6
Helix angle	8 degrees
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		