

Garant

Solid carbide milling cutter Composite, compacting cut, Diamond, Ø h10 DC: 4mm



Order data

Order number	209548 4
GTIN	4062406362379
Item class	100

Description

Version:

Specifically **developed Tool cutting edge has been specifically developed further** for optimum machining of composite materials.
Length similar to **DIN 6527 long**.
Left-hand helix, **compacting cut**. The material is pushed down on to the substrate. Highly suitable for thin materials.

Technical description

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

Overall length L	57 mm
Tolerance nominal \varnothing	h10
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		