

## Garant

### Solid carbide milling cutter Composite, compacting cut, Diamond, Ø h10 DC: 8Mmm



#### Order data

Order number	209548 8M
GTIN	4062406362423
Item class	100

#### Description

##### Version:

Specifically **developed Tool cutting edge has been specifically developed further** for optimum machining of composite materials.<br>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	DIN 6535 HA to h6
Recess Ø D <sub>1</sub>	7.8 mm
Shank Ø D <sub>s</sub>	8 mm
Helix angle	8 degrees
No. of teeth Z	8
Overall length L	70 mm
Flute length L <sub>c</sub>	22 mm
Direction of infeed	horizontal, oblique and vertical
Corner chamfer width at 45°	0.16 mm
Corner chamfer angle	45 degrees
Feed f <sub>z</sub> for slot milling in GRP CRP	0.031 mm
Tolerance nominal Ø	h10

Cutting edge $\varnothing D_c$	8 mm
Overhang length $L_1$ incl. recess	32 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		