

**Garant**
**Solid carbide milling cutter Composite, dragging cut, uncoated, Ø h10 DC: 8Mmm**

**Order data**

|              |               |
|--------------|---------------|
| Order number | 209540 8M     |
| GTIN         | 4062406362522 |
| Item class   | 100           |

**Description**
**Version:**

**Tool cutting edge has been specifically developed further** for optimum machining of composite materials.<br>Length similar to **DIN 6527 long**.

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

**Technical description**

|                                    |                                  |
|------------------------------------|----------------------------------|
| Overhang length $L_1$ incl. recess | 32 mm                            |
| Recess $\varnothing D_1$           | 7.8 mm                           |
| Flute length $L_c$                 | 22 mm                            |
| Corner chamfer angle               | 45 degrees                       |
| No. of teeth Z                     | 8                                |
| Direction of infeed                | horizontal, oblique and vertical |
| Tolerance nominal $\varnothing$    | h10                              |
| Overall length L                   | 70 mm                            |
| Cutting edge $\varnothing D_c$     | 8 mm                             |
| Shank                              | DIN 6535 HA to h6                |
| Corner chamfer width at 45°        | 0.16 mm                          |
| Helix angle                        | 8 degrees                        |

|   |                                      |
|---|--------------------------------------|
| Feed $f_z$ for slot milling in GRP CRP    | 0.031 mm                             |
| Shank $\varnothing D_s$                   | 8 mm                                 |
| Coating                                   | uncoated                             |
| 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    | 80 m/min  | N        |
| POM GF25           | suitable    | 80 m/min  | N        |
| PA 66 GF30         | suitable    | 80 m/min  | N        |
| PEEK GF30          | suitable    | 80 m/min  | N        |
| PTFE CF25          | suitable    | 80 m/min  | N        |
| PEEK CF30          | suitable    | 80 m/min  | N        |
| Hybrids            | suitable    |           |          |
| Honeycomb sandwich | suitable    | 165 m/min | N        |
| CRP                | suitable    | 120 m/min | N        |
| GRP, CRP           | suitable    | 120 m/min | N        |
| Graphite           | suitable    | 180 m/min | N        |
| wet maximum        | suitable    |           |          |
| dry                | suitable    |           |          |
| Air                | suitable    |           |          |