

## Garant

### Solid carbide milling cutter Composite, compacting cut, Diamond, Ø h10 DC: 12mm



#### Order data

Order number	209548 12
GTIN	4062406362447
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 Ø D <sub>s</sub>	12 mm
Recess Ø D <sub>1</sub>	11.6 mm
Helix angle	8 degrees
Direction of infeed	horizontal, oblique and vertical
Flute length L <sub>c</sub>	26 mm
Feed f <sub>z</sub> for slot milling in GRP CRP	0.038 mm
Cutting edge Ø D <sub>c</sub>	12 mm
Overall length L	83 mm
Tolerance nominal Ø	h10
Corner chamfer angle	45 degrees
Overhang length L <sub>1</sub> incl. recess	36 mm
Shank	DIN 6535 HA to h6

Corner chamfer width at 45°	0.24 mm
No. of teeth Z	8
Coating	Diamond
Tool material	Solid carbide
Standard	DIN 6527
Cutting width $a_e$ for milling operation	Full slot cutting depth 1×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		