

Garant

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



Order data

Order number	209548 20
GTIN	4062406362461
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

Corner chamfer width at 45°	0.4 mm
Overall length L	104 mm
Recess Ø D ₁	19.4 mm
Flute length L _c	38 mm
Tolerance nominal Ø	h10
Helix angle	8 degrees
Feed f _z for slot milling in GRP CRP	0.043 mm
Shank Ø D _s	20 mm
Shank	DIN 6535 HA to h6
Corner chamfer angle	45 degrees
Cutting edge Ø D _c	20 mm
Direction of infeed	horizontal, oblique and vertical

Overhang length L_1 incl. recess	52 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 $1 \times D$
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		