

Garant

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



Order data

Order number	209542 4
GTIN	4062406366124
Item class	100

Description

Version:

Tool cutting edge has been specifically developed further for optimal machining of composite materials.

Overall 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

Overhang length L_1 incl. recess	19 mm
Cutting edge $\varnothing D_c$	4 mm
Shank	DIN 6535 HA to h6
Feed f_z for slot milling in GRP CRP	0.021 mm
Shank $\varnothing D_s$	6 mm
No. of teeth Z	8
Overall length L	57 mm
Flute length L_c	11 mm
Corner chamfer angle	45 degrees
Tolerance nominal \varnothing	h10
Corner chamfer width at 45°	0.08 mm

Recess $\varnothing D_1$	3.9 mm
Helix angle	8 degrees
Direction of infeed	horizontal, oblique and vertical
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		

