

**Garant**
**Solid carbide milling cutter Composite, compacting cut, uncoated, Ø h10 DC: 6Mmm**

**Order data**

Order number	209542 6M
GTIN	4062406366155
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**

Helix angle	8 degrees
Cutting edge Ø D <sub>c</sub>	6 mm
Flute length L <sub>c</sub>	21 mm
Corner chamfer width at 45°	0.12 mm
Direction of infeed	horizontal, oblique and vertical
Recess Ø D <sub>1</sub>	5.8 mm
Overhang length L <sub>1</sub> incl. recess	27 mm
Overall length L	65 mm
Corner chamfer angle	45 degrees
Shank	DIN 6535 HA to h6
Shank Ø D <sub>s</sub>	6 mm

Tolerance nominal $\varnothing$	h10
Feed $f_z$ for slot milling in GRP CRP	0.026 mm
No. of teeth Z	8
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		

