

**Garant**
**Solid carbide milling cutter straight cut, Diamond, Ø h10 DC: 4mm**

**Order data**

|              |               |
|--------------|---------------|
| Order number | 209525 4      |
| GTIN         | 4045197478269 |
| Item class   | 11Y           |

**Description**
**Version:**

High performance geometry with multiple teeth for extremely high material removal rates in a single pass.

**Straight flutes** for a neutral cut.

**Technical description**

|  |                                  |
|--|----------------------------------|
| Cutting edge Ø D <sub>c</sub>                    | 4 mm                             |
| Corner chamfer width at 45°                      | 0.08 mm                          |
| Feed f <sub>z</sub> for slot milling in GRP CRP  | 0.03 mm                          |
| No. of teeth Z                                   | 8                                |
| Feed f <sub>z</sub> for slot milling in graphite | 0.03 mm                          |
| Shank Ø D <sub>s</sub>                           | 6 mm                             |
| Overall length L                                 | 60 mm                            |
| Flute length L <sub>c</sub>                      | 16 mm                            |
| Direction of infeed                              | horizontal, oblique and vertical |
| Shank  | DIN 6535 HA with h6              |
| Tolerance nominal Ø                              | h10                              |
| Corner chamfer angle                             | 45 degrees                       |
| Coating  | Diamond                          |
| Tool material                                    | Solid carbide                    |

|   |                                      |
|---|--------------------------------------|
| Standard                                  | Manufacturer's standard              |
| 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    | 200 m/min | N        |
| POM GF25           | suitable    | 190 m/min | N        |
| PA 66 GF30         | suitable    | 170 m/min | N        |
| PEEK GF30          | suitable    | 150 m/min | N        |
| PTFE CF25          | suitable    | 180 m/min | N        |
| PEEK CF30          | suitable    | 160 m/min | N        |
| Hybrids            | suitable    |           |          |
| Honeycomb sandwich | suitable    | 350 m/min | N        |
| GRP                | suitable    | 190 m/min | N        |
| GRP, CRP           | suitable    | 190 m/min | N        |
| Graphite           | suitable    | 340 m/min | N        |
| wet maximum        | Suitable    |           |          |
| dry                | Suitable    |           |          |
| Air                | suitable    |           |          |

## Services

|                        |           |
|------------------------|-----------|
| Shank grinding Type HB | 129100 HB |
|------------------------|-----------|