

**Garant**
**Solid carbide milling cutter, DLC, Ø DC: 12Mmm**

**Order data**

Order number	202515 12M
GTIN	4045197692597
Item class	11X

**Description**
**Version:**
**Extra sharp cutting edges.**

Dimensions similar to DIN 6527.

With the latest generation of **DLC coating sp<sup>2</sup>**.

**Technical description**

Cutting edge Ø D <sub>c</sub>	12 mm
Feed f <sub>z</sub> for side milling in short-chipping aluminium	0.09 mm
No. of teeth Z	4
Feed f <sub>z</sub> for slot milling in short-chipping aluminium	0.05 mm
Shank Ø D <sub>s</sub>	12 mm
Overall length L	93 mm
Flute length L <sub>c</sub>	36 mm
Direction of infeed	horizontal, oblique and vertical
Shank	DIN 6535 HA to h6
Tolerance nominal Ø	e8
Helix angle	45 degrees
Corner chamfer angle	90 degrees
Coating	DLC

Tool material	Solid carbide
Standard	DIN 6527
Type	W
Cutting width $a_e$ for milling operation	0.25×D for side milling
Cutting width $a_e$ for milling operation	Full slot cutting depth 1×D
Through-coolant	no
Colour ring	yellow
Type of product	End / face mill

### User data

	Suitability	$V_c$	ISO code
Aluminium	suitable	480 m/min	N
Aluminium (short chipping)	suitable	440 m/min	N
Alu > 10% Si	suitable	400 m/min	N
PMMA acrylic	Suitable	200 m/min	N
PE-HD	Suitable	160 m/min	N
PA 66	Suitable	200 m/min	N
PEEK	Suitable	150 m/min	N
PF 31	Suitable	130 m/min	N
PVDF GF20	suitable	180 m/min	N
POM GF25	Suitable	160 m/min	N
PA 66 GF30	suitable	150 m/min	N
PEEK GF30	suitable	130 m/min	N
PTFE CF25	suitable	160 m/min	N
Honeycomb sandwich	suitable	300 m/min	N
Cu	Suitable	160 m/min	N
CuZn	Suitable	200 m/min	N
wet maximum	suitable		

wet minimum	suitable
dry	suitable only under restricted conditions
Air	suitable
<b>Services</b>	
Shank grinding Type HB	129100 HB