

**Garant**
**Solid carbide milling cutter, Diamond, Ø f8 DC: 12mm**

**Order data**

Order number	209713 12
GTIN	4045197512536
Item class	11Y

**Description**
**Version:**

With the latest generation of **crystalline diamond coating sp<sup>3</sup>**, for process reliability in machining **fibre-reinforced composites, CRP, GRP, and graphite.**

**Dynamic cutter geometry.**
**Technical description**

No. of teeth Z	4
Recess Ø D <sub>1</sub>	11.7 mm
Cutting edge Ø D <sub>c</sub>	12 mm
Feed f <sub>z</sub> for slot milling in GRP CRP	0.06 mm
Feed f <sub>z</sub> for slot milling in graphite	0.06 mm
Overhang length L <sub>1</sub> incl. recess	36 mm
Corner chamfer width at 45°	0.3 mm
Shank Ø D <sub>s</sub>	12 mm
Overall length L	83 mm
Flute length L <sub>c</sub>	26 mm
Direction of infeed	horizontal, oblique and vertical
Shank	DIN 6535 HA with h6
Tolerance nominal Ø	f8

Balance quality with shank	G 2.5 with HA
Helix angle	45 degrees
Corner chamfer angle	45 degrees
Coating	Diamond
Tool material	Solid carbide
Standard	Manufacturer's standard
Spacing of the cutters	unequal spacing
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 minimum	suitable		
dry	Suitable		
Air	suitable		

## Services

Shank grinding Type HB

129100 HB