

Garant**PCD face mill with bore, PCD, Ø D: 40mm****Order data**

Order number	209810 40
GTIN	4069515014861
Item class	11Y

Description**Version:**

High-performance PCD face mill for **roughing and finish machining**. **Generous flutes** for reliable evacuation of the chips. Coolant directly on the cutting edge. Axial angle 6° positive.

Supplied with:

Special fastening screw for optimal coolant feed.

Note:

Matching face mill arbors are located in the clamping device area, e.g. No. 306530 22. PCD face mill with corner radius 0.1 mm – 1.5 mm are available on request.

Technical description

Overall length L	40 mm
Feed f_z for slot milling in cast aluminium	0.2 mm
Ø D ₃	32 mm
Bore Ø	16
Corner chamfer width at 45°	0.1 mm
maximum infeed, indexable insert, secondary cutting edge	10 mm

Data sheet

No. of teeth Z	4
axial rake angle, tool	6
Cutting edge $\varnothing D_c$	40 mm
Shank type	with bore
Ramping angle $\alpha_{\max}$	0.6 degrees
Coating	PCD
Tool material	PCD
Standard	Works standard
Type	N
Tolerance nominal $\varnothing$	± 0.02
Direction of infeed	horizontal, oblique and vertical
Cutting width a_e for milling operation	$0.3 \times D$ for side milling
Through-coolant	yes
Corner chamfer angle	45 degrees
Machining strategy	HPC
Type of product	Face Mill

User data

	Suitability	V_c	ISO code
Aluminium	suitable	6000 m/min	N
Aluminium (short chipping)	suitable	6000 m/min	N
Alu > 10% Si	suitable	2000 m/min	N
PMMA acrylic	suitable	2000 m/min	N
PE-HD	suitable	2000 m/min	N
PA 66	suitable only under restricted conditions	2000 m/min	N
PEEK	suitable only under restricted conditions	2000 m/min	N

Data sheet

PF 31	suitable only under restricted conditions	2000 m/min	N
AFRP aramid	suitable only under restricted conditions	2000 m/min	N
PVDF GF20	suitable only under restricted conditions	2000 m/min	N
POM GF25	suitable only under restricted conditions	2000 m/min	N
PA 66 GF30	suitable only under restricted conditions	2000 m/min	N
PEEK GF30	suitable only under restricted conditions	2000 m/min	N
PTFE CF25	suitable only under restricted conditions	2000 m/min	N
PEEK CF30	suitable only under restricted conditions	2000 m/min	N
Cu	suitable	6000 m/min	N
CuZn	suitable	2000 m/min	N
Oil	suitable		
wet maximum	suitable		
wet minimum	suitable		
dry	suitable		
Air	suitable		