

Garant**Solid carbide milling cutter, Diamond, Ø h10 DC: 6mm****Order data**

Order number	209517 6
GTIN	4045197468307
Item class	10Y

Description**Version:**

Twisted and curved cutting edges, which enable **burr-free milling** of both the upper and lower edges of fibre-reinforced composites.

Delamination is prevented because the cutter performs a cut which is simultaneously dragging and compacting. The cutter must be positioned centrally to the cross section of the material.

Technical description

Feed f_z for side milling in GRP CRP	0.06 mm
No. of teeth Z	4
Cutting edge Ø D_c	6 mm
Cutting section dragging L_A	10 mm
Shank Ø D_s	6 mm
Overall length L	65 mm
Flute length L_c	21 mm
Direction of infeed	horizontal and oblique
Shank	DIN 6535 HA with h6
Tolerance nominal Ø	h10
Corner chamfer angle	90 degrees
Coating	Diamond
Tool material	Solid carbide

Standard	Manufacturer's standard
Cutting width a_e for milling operation	0.5×D for side milling
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
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