

**Garant**
**Solid carbide milling cutter Composite, dragging cut, uncoated, Ø h10 DC: 6mm**

**Order data**

Order number	209540 6
GTIN	4062406362492
Item class	100

**Description**
**Version:**

**Tool cutting edge has been specifically developed further** for optimum machining of composite materials.<br>Length similar to **DIN 6527 long**.  
Right-hand helix, **dragging cut** for standard applications.

**Technical description**

Direction of infeed	horizontal, oblique and vertical
Feed $f_z$ for slot milling in GRP CRP	0.026 mm
Flute length $L_c$	13 mm
Corner chamfer width at 45°	0.12 mm
Recess $\varnothing D_1$	5.8 mm
Cutting edge $\varnothing D_c$	6 mm
Helix angle	8 degrees
Shank	DIN 6535 HA to h6
Overall length L	57 mm
Tolerance nominal $\varnothing$	h10
Overhang length $L_1$ incl. recess	19 mm
Corner chamfer angle	45 degrees

Shank $\varnothing D_s$	6 mm
No. of teeth Z	8
Coating	uncoated
Tool material	Solid carbide
Standard	DIN 6527
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	80 m/min	N
POM GF25	suitable	80 m/min	N
PA 66 GF30	suitable	80 m/min	N
PEEK GF30	suitable	80 m/min	N
PTFE CF25	suitable	80 m/min	N
PEEK CF30	suitable	80 m/min	N
Hybrids	suitable		
Honeycomb sandwich	suitable	165 m/min	N
CRP	suitable	120 m/min	N
GRP, CRP	suitable	120 m/min	N
Graphite	suitable	180 m/min	N
wet maximum	suitable		
dry	suitable		
Air	suitable		