

Garant

GARANT Master Steel solid carbide roughing end mill HPC, TiAlN, Ø f8 DC: 6mm



Order data

Order number	203039 6
GTIN	4062406230906
Item class	11X

Description

Version:

For **roughing and finishing**.

Up to 1.5xD into solid material **at very high feed rates** with smooth cutting action.

Advantage:

Optimised flute form, eccentric relief ground, generous chip spaces.

Tolerance nominal Ø: f8

No. of teeth Z: 4

Helix angle: 38 °

Direction of infeed: horizontal, oblique and vertical

Shank: DIN 6535 HB to h6

No. of teeth Z: 4

Flute length L_c : 13 mm

Overhang length L_1 incl. recess: 20 mm

Recess Ø D_1 : 5.8 mm

Overall length L: 57 mm

Shank Ø D_s : 6 mm

Technical description

Tolerance nominal Ø	f8
Shank	DIN 6535 HB to h6
Direction of infeed	horizontal, oblique and vertical
Feed f_z for slot milling in steel < 900 N/mm ²	0.04 mm
Corner chamfer width at 45°	0.1 mm

Flute length L_c	13 mm
Cutting edge $\varnothing D_c$	6 mm
Shank $\varnothing D_s$	6 mm
Feed f_z for side milling in steel < 900 N/mm ²	0.05 mm
Recess $\varnothing D_1$	5.8 mm
Overall length L	57 mm
No. of teeth Z	4
Overhang length L_1 incl. recess	20 mm
Helix angle	38 °
Corner chamfer angle	45 °
Series	Master Steel
Coating	TiAlN
Tool material	Solid carbide
Standard	DIN 6527
Type	N
Helix angle characteristic	unequal spacing
Spacing of the cutters	unequal spacing
Cutting width a_e for milling operation	Full slot cutting depth 1×D
Cutting width a_e for milling operation	0.03×D for copy milling
Through-coolant	no
Machining strategy	HPC
Colour ring	green
Type of product	End / face mill

User data

	Suitability	V_c	ISO code
Steel < 500 N/mm ²	suitable	260 m/min	P
Steel < 750 N/mm ²	suitable	240 m/min	P
Steel < 900 N/mm ²	suitable	190 m/min	P

Steel < 1100 N/mm ²	suitable	180 m/min	P
Steel < 1400 N/mm ²	suitable only under restricted conditions	150 m/min	P
INOX < 900 N/mm ²	suitable	80 m/min	M
INOX > 900 N/mm ²	suitable	70 m/min	M
GG(G)	suitable	250 m/min	K
Uni	suitable		
wet maximum	suitable		
wet minimum	suitable only under restricted conditions		
dry	suitable		
Air	suitable		