

Garant

GARANT Master Alu solid carbide milling cutter, HPC HPC, uncoated, Ø e8 DC: 6mm



Order data

Order number	203208 6
GTIN	4062406565916
Item class	11X

Description

Version:

For finishing operations.

Special geometry for optimum chip evacuation.

Unequal spacing gives high intrinsic stability and smooth cutting action.

For profile milling as a finishing operation.

Tolerance nominal Ø: e8

No. of teeth Z: 5

Helix angle: 38 °

Direction of infeed: horizontal

Shank: DIN 6535 HA to h6

Balance quality with shank: G 2.5 with HA

No. of teeth Z: 5

Flute length L_c : 24 mm

Overhang length L_1 incl. recess: 32 mm

Recess Ø D_1 : 5.8 mm

Overall length L: 65 mm

Shank Ø D_s : 6 mm

Technical description

Feed f_z for side milling in short-chipping aluminium	0.045 mm
Corner chamfer angle	90 °
Helix angle	38 °
Recess Ø D_1	5.8 mm

Direction of infeed	horizontal
Overhang length L_1 incl. recess	32 mm
Shank $\varnothing D_s$	6 mm
Flute length L_c	24 mm
Tolerance nominal \varnothing	e8
Cutting edge $\varnothing D_c$	6 mm
Shank	DIN 6535 HA to h6
Balance quality with shank	G 2.5 with HA
Overall length L	65 mm
No. of teeth Z	5
Series	Master Alu
Coating	uncoated
Tool material	Solid carbide
Standard	Manufacturer's standard
Type	W
Spacing of the cutters	unequal spacing
Cutting width a_e for milling operation	$0.1 \times D$ for side milling
Through-coolant	no
Machining strategy	HPC
Colour ring	yellow
Type of product	End / face mill

User data

	Suitability	V_c	ISO code
Aluminium	Suitable	500 m/min	N
Aluminium (short chipping)	suitable	450 m/min	N
Alu > 10% Si	suitable	400 m/min	N
PMMA acrylic	Suitable	180 m/min	N

PE-HD	Suitable	140 m/min	N
PA 66	Suitable	180 m/min	N
PEEK	Suitable	130 m/min	N
PF 31	Suitable	110 m/min	N
PVDF GF20	Suitable	160 m/min	N
POM GF25	Suitable	140 m/min	N
PA 66 GF30	Suitable	140 m/min	N
PEEK GF30	Suitable	120 m/min	N
PTFE CF25	Suitable	140 m/min	N
Honeycomb sandwich	suitable only under restricted conditions	260 m/min	N
Cu	Suitable	140 m/min	N
CuZn	suitable	120 m/min	N
wet maximum	Suitable		
wet minimum	suitable only under restricted conditions		
dry	suitable		
Air	suitable		

Services

Shank grinding Type HB

129100 HB