

Garant
GARANT Master Steel SlotMachine solid carbide roughing end mill HPC, TiAlN, Ø d11 DC: 6mm

Order data

Order number	205552 6
GTIN	4045197958952
Item class	11X

Description
Version:

With a new-type knurled profile, optimised for higher feed rates. Improved cutting edge protection thanks to slight edge honing. Tremendous bending strength due to the use of ultra-fine grain substrate.

Advantage:

The tool geometry produces particularly tightly rolled swarf that is discharged via flat chip breaker recesses. As a result, the tool maintains an extremely stable core. Plunge angle of up to 10° possible thanks to generous recess on the front face.

Application:

For roughing machining, particularly suitable for full-slot machining.

Tolerance nominal Ø: d11

No. of teeth Z: 5

Helix angle: 42°

Direction of infeed: horizontal, oblique and vertical

Shank: DIN 6535 HB to h6

No. of teeth Z: 5

Flute length L_c : 13 mm

Overhang length L_1 incl. recess: 25 mm

Recess Ø D_1 : 5.6 mm

Overall length L: 62 mm

Shank Ø D_s : 6 mm

Technical description

Overall length L	62 mm
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Feed f_z for side milling in steel < 900 N/mm ²	0.045 mm
Direction of infeed	horizontal, oblique and vertical
Shank	DIN 6535 HB to h6
Tolerance nominal \varnothing	d11
Cutting edge $\varnothing D_c$	6 mm
Helix angle	42 °
No. of teeth Z	5
Corner chamfer width at 45°	0.3 mm
Shank $\varnothing D_s$	6 mm
Flute length L_c	13 mm
Recess $\varnothing D_1$	5.6 mm
Feed f_z for slot milling in steel < 900 N/mm ²	0.035 mm
Overhang length L_1 incl. recess	25 mm
Corner chamfer angle	45 °
Series	Master Steel
Coating	TiAlN
Tool material	Solid carbide
Standard	Manufacturer's standard
Milling profile	NR
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	0.4×D for side milling
Through-coolant	no
Machining strategy	HPC
Colour ring	green
Type of product	End / face mill

User data

	Suitability	V_c	ISO code
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Steel < 500 N/mm ²	suitable	200 m/min	P
Steel < 750 N/mm ²	suitable	180 m/min	P
Steel < 900 N/mm ²	suitable	160 m/min	P
Steel < 1100 N/mm ²	suitable	140 m/min	P
Steel < 1400 N/mm ²	suitable	110 m/min	P
INOX < 900 N/mm ²	suitable	50 m/min	M
INOX > 900 N/mm ²	suitable	35 m/min	M
GG(G)	suitable	200 m/min	K
Uni	suitable		
wet maximum	suitable		
Air	suitable		