

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

Order data

Order number	205555 6
GTIN	4062406275624
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.

Application:

For roughing machining.

Problem-solver for TPC 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 : 24 mm

Overall length L: 66 mm

Shank Ø D_s : 6 mm

Corner chamfer width at 45°: 0.3 mm

Feed f_z for slot milling in steel < 900 N/mm²: 0.03 mm

Technical description

Corner chamfer angle	45°
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Flute length L_c	24 mm
Shank	DIN 6535 HB to h6
No. of teeth Z	5
Overall length L	66 mm
Tolerance nominal \varnothing	d11
Shank $\varnothing D_s$	6 mm
Feed f_z for slot milling in steel < 900 N/mm ²	0.03 mm
Direction of infeed	horizontal, oblique and vertical
Feed f_z for side milling in steel < 900 N/mm ²	0.04 mm
Cutting edge $\varnothing D_c$	6 mm
Helix angle	42°
Corner chamfer width at 45°	0.3 mm
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	0.2×D for side milling
Through-coolant	no
Machining strategy	HPC
Machining strategy	TPC
Colour ring	green
Type of product	End / face mill

User data

	Suitability	V_c	ISO code
Steel < 500 N/mm ²	suitable	180 m/min	P
Steel < 750 N/mm ²	suitable	170 m/min	P

Steel < 900 N/mm ²	suitable	150 m/min	P
Steel < 1100 N/mm ²	suitable	130 m/min	P
Steel < 1400 N/mm ²	suitable	100 m/min	P
INOX < 900 N/mm ²	suitable	45 m/min	M
INOX > 900 N/mm ²	suitable	30 m/min	M
GG(G)	suitable	180 m/min	K
Uni	suitable		
wet maximum	suitable		
wet minimum	suitable only under restricted conditions		
dry	suitable		
Air	suitable		