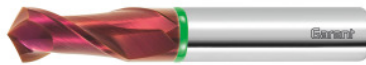


Garant
Solid carbide chamfer mill, spiral flutes 120°, TiAlN, Ø e8 DC: 6mm

Order data

| | |
|--------------|---------------|
| Order number | 208089 6 |
| GTIN | 4062406390662 |
| Item class | 11X |

Description
Version:

Outstanding surface qualities thanks to the **35° helix angle**. Chamfer mill for **universal application** in virtually all materials. The newly developed coating effectively prevents built-up edges, even in aluminium or stainless steel.

Tolerance: Point angle ± 5 arc minutes.

Application:

- **Centring**
- **Drilling**
- **Countersinking**
- **Chamfering**

Technical description

| | |
|---|-------------------|
| Feed f_z for side milling in steel $< 900 \text{ N/mm}^2$ | 0.05 mm |
| Corner chamfer angle | 60 degrees |
| No. of teeth Z | 2 |
| Cutting edge $\varnothing D_c$ | 6 mm |
| Flute length L_c | 13 mm |
| Shank | DIN 6535 HA to h6 |
| Chamfer mill | 60 degrees |
| Overall length L | 57 mm |
| Shank $\varnothing D_s$ | 6 mm |

| | |
|---|-------------------------|
| Feed f_z for side milling in INOX > 900 N/mm ² | 0.045 mm |
| Coating | TiAlN |
| Tool material | Solid carbide |
| Standard | Manufacturer's standard |
| Type | N |
| Tolerance nominal \varnothing | e8 |
| Helix angle | 35 degrees |
| Cutting width a_e for milling operation | 0.5×D for side milling |
| Countersink tip angle | 120 degrees |
| Through-coolant | no |
| Shank tolerance | h6 |
| Colour ring | green |
| Type of product | Indexable end mill |

User data

| | Suitability | V_c | ISO code |
|--------------------------------|---|-----------|----------|
| Alu plastics | suitable only under restricted conditions | 180 m/min | N |
| Aluminium (short chipping) | suitable | 300 m/min | N |
| Alu > 10% Si | suitable | 220 m/min | N |
| Steel < 500 N/mm ² | suitable | 130 m/min | P |
| Steel < 750 N/mm ² | suitable | 115 m/min | P |
| Steel < 900 N/mm ² | suitable | 110 m/min | P |
| Steel < 1100 N/mm ² | suitable | 80 m/min | P |
| Steel < 1400 N/mm ² | suitable only under restricted conditions | 65 m/min | P |
| Steel < 55 HRC | suitable only under restricted conditions | 35 m/min | H |
| INOX < 900 N/mm ² | suitable | 90 m/min | M |

| | | | |
|------------------------------|---|-----------|---|
| INOX > 900 N/mm ² | suitable | 70 m/min | M |
| Ti > 850 N/mm ² | suitable | 50 m/min | S |
| GG(G) | suitable | 100 m/min | K |
| Uni | suitable | | |
| wet maximum | suitable | | |
| wet minimum | suitable only under restricted conditions | | |
| dry | suitable only under restricted conditions | | |
| Air | Suitable only under restricted conditions | | |

Services

Shank grinding Type HB

129100 HB