

**Garant****Solid carbide side milling cutter HPC, TiAlN,  $\varnothing \times \text{width} \pm 0.1 \times k11$ : 80X6mm****Order data**

Order number	185015 80X6
GTIN	4062406397524
Item class	11V

**Description****Version:**

**Precision solid carbide side milling cutters** in the HPC machining range. **With new high-performance coating** for very long tool life.

**Use as a set:** Cutters with the same  $\varnothing$  and same number of teeth can be combined as a set and adjusted to the required width. Since the cutters have no raised bore collar, the staggered teeth mesh with each other.

**2-piece sets are particularly economical.** By reversing the side milling cutters, both side edges of each cutter can be used.

**Note:**

- **Do not clamp the cutters in a set without a sufficiently thick arbor spacer ring, otherwise the cutters will be damaged.**
- **See Product Group 30 for suitable arbor spacer rings.**
- **Slots milled from solid:  $f_z$  for  $a_e = 0.1 \times D$ .**

**Successor product to No. 185010.**

**Technical description**

Capability of combining 2 cutters of different width, results in overall width E	13 - 13.8 mm
Bore $\varnothing$ H6 d <sub>1</sub>	27 mm
Capability of combining 2 cutters of the same width, results in overall width E	10.7 - 11.8 mm
No. of teeth Z	18
Feed f <sub>z</sub> in steel < 900 N/mm <sup>2</sup>	0.05 mm
Cutting width	6 mm
Capability of combining 2 cutters of the same width A/B	6 mm
Tooth height Zh	15 mm
Cutting edge $\varnothing$ D <sub>c</sub>	80 mm
Capability of combining 2 cutters of different width B	8 mm
Collar $\varnothing$ d <sub>2</sub> ±1	50 mm
Capability of combining 2 cutters of different width A	6 mm
Collar thickness b ±0.1	3.5 mm
Shank type	with bore
Coating	TiAlN
Tool material	Solid carbide
Standard	DIN 885 A
Type	N
Tolerance nominal $\varnothing$	± 0.1
Cutting width a <sub>e</sub> for milling operation	Full slot cutting depth 1×D
Machining strategy	HPC
Through-coolant	no
Colour ring	without
Type of product	Side milling cutter

## User data

	Suitability	V <sub>c</sub>	ISO code
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Alu plastics	suitable	280 m/min	N
Aluminium (short chipping)	suitable	280 m/min	N
Alu > 10% Si	suitable	200 m/min	N
Steel < 500 N/mm <sup>2</sup>	suitable	120 m/min	P
Steel < 750 N/mm <sup>2</sup>	suitable	110 m/min	P
Steel < 900 N/mm <sup>2</sup>	suitable	100 m/min	P
Steel < 1100 N/mm <sup>2</sup>	suitable	90 m/min	P
Steel < 1400 N/mm <sup>2</sup>	suitable	75 m/min	P
INOX < 900 N/mm <sup>2</sup>	suitable	45 m/min	M
GG(G)	suitable	70 m/min	K
CuZn	suitable	300 m/min	N
Oil	suitable only under restricted conditions		
wet maximum	suitable		