

**Garant**
**Solid carbide milling cutter HPC, TiAlN, Ø DC: 6mm**

**Order data**

|              |               |
|--------------|---------------|
| Order number | 203009 6      |
| GTIN         | 4045197588623 |
| Item class   | 11X           |

**Description**
**Version:**

Specially for **machining stainless steels such as duplex steels at high rates of metal removal.**  
 Cutting edge chamfer: Size 4 = 0.07mm; size 5 – 8 = 0.12 mm; size 10 – 18 = 0.2 mm; ≥ size 20 = 0.3 mm

**Technical description**

|   |                                  |
|---|----------------------------------|
| Feed $f_z$ for slot milling in stainless steel $> 900 \text{ N/mm}^2$ | 0.025 mm                         |
| Corner chamfer width at $45^\circ$                                    | 0.12 mm                          |
| Cutting edge $\varnothing D_c$  | 6 mm                             |
| Overhang length $L_1$ incl. recess                                    | 20 mm                            |
| No. of teeth Z  | 4                                |
| Feed $f_z$ for side milling in INOX $> 900 \text{ N/mm}^2$            | 0.04 mm                          |
| Recess $\varnothing D_1$  | 5.8 mm                           |
| Shank $\varnothing D_s$   | 6 mm                             |
| Overall length L  | 57 mm                            |
| Flute length $L_c$  | 13 mm                            |
| Direction of infeed   | horizontal, oblique and vertical |
| Shank   | DIN 6535 HB to h6                |
| Tolerance nominal $\varnothing$                                       | h10                              |

|   |                             |
|---|-----------------------------|
| Helix angle                               | 38 degrees                  |
| Corner chamfer angle                      | 45 degrees                  |
| Coating                                   | TiAlN                       |
| Tool material                             | Solid carbide               |
| Standard                                  | DIN 6527                    |
| Type                                      | N                           |
| Helix angle characteristic                | unequal spacing             |
| Spacing of the cutters                    | unequal spacing             |
| Cutting width $a_e$ for milling operation | 0.3×D for side milling      |
| Cutting width $a_e$ for milling operation | Full slot cutting depth 1×D |
| Through-coolant                           | no                          |
| Machining strategy                        | HPC                         |
| Colour ring                               | blue                        |
| Type of product                           | End / face mill             |

### User data

|                              | Suitability                               | $V_c$     | ISO code |
|------------------------------|---|-----------|----------|
| INOX < 900 N/mm <sup>2</sup> | suitable                                  | 110 m/min | M        |
| INOX > 900 N/mm <sup>2</sup> | suitable                                  | 90 m/min  | M        |
| wet maximum                  | suitable                                  |           |          |
| wet minimum                  | suitable                                  |           |          |
| dry                          | Suitable only under restricted conditions |           |          |
| Air                          | suitable                                  |           |          |