

Garant
Solid carbide roughing end mill HPC, AlCrN, Ø e8 DC: 6mm

Order data

Order number	203072 6
GTIN	4062406565169
Item class	11X

Description
Version:

For **roughing and finishing**. Up to 1.5×D into solid material **at very high feed rates** with smooth cutting action. Optimised end face geometry.

Application:

- **Optimised flute form, eccentric relief ground.**
- **Large flute profiles.**
- **Improved chip evacuation due to optimised end face geometry.**
- **Minimal wear due to sturdy cutting edges.**

Technical description

Tolerance nominal Ø	e8
Flute length L_c	13 mm
Feed f_z for slot milling in steel < 900 N/mm ²	0.034 mm
Shank Ø D_s	6 mm
Overall length L	57 mm
Helix angle	38 degrees
Corner chamfer angle	45 degrees
Overhang length L_1 incl. recess	20 mm
Recess Ø D_1	5.8 mm
Direction of infeed	horizontal, oblique and vertical

No. of teeth Z	4
Cutting edge $\varnothing D_c$	6 mm
Feed f_z for side milling in steel $< 900 \text{ N/mm}^2$	0.07 mm
Shank	DIN 6535 HB to h6
Corner chamfer width at 45°	0.1 mm
Coating	AlCrN
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	$0.3 \times D$ for side milling
Cutting width a_e for milling operation	Full slot cutting depth $1 \times D$
Through-coolant	no
Machining strategy	MTC
Colour ring	green
Type of product	End / face mill

User data

	Suitability	V_c	ISO code
Steel $< 500 \text{ N/mm}^2$	suitable	265 m/min	P
Steel $< 750 \text{ N/mm}^2$	suitable	250 m/min	P
Steel $< 900 \text{ N/mm}^2$	suitable	200 m/min	P
Steel $< 1100 \text{ N/mm}^2$	suitable	180 m/min	P
Steel $< 1400 \text{ N/mm}^2$	suitable only under restricted conditions	160 m/min	P
INOX $< 900 \text{ N/mm}^2$	suitable only under restricted conditions	100 m/min	M
INOX $> 900 \text{ N/mm}^2$	suitable only under restricted conditions	90 m/min	M

GG(G)	suitable	250 m/min	K
Uni	suitable		
wet maximum	suitable		
wet minimum	suitable only under restricted conditions		
dry	suitable		
Air	suitable		