

Garant
Solid carbide high precision milling cutter, TiAlN, Ø f8 DC: 6mm

Order data

Order number	203530 6
GTIN	4045197352804
Item class	11X

Description
Version:

High stability and **extremely smooth cutting action** due to at least 6 teeth. **Eccentric relief ground.**

Extremely **high taper accuracy with tolerances in the µm range**, for **precise 90° angles** and plane-parallel surfaces in profile milling.

For the most demanding angular accuracy.

Cutter corner chamfer undefined due to eccentric relief grinding.

With maximum 0.008 mm tapering.

Application:

For peripheral milling as a **finishing operation.**

Technical description

No. of teeth Z	6
Cutting edge Ø D _c	6 mm
Feed f _z for side milling in steel < 900 N/mm ²	0.04 mm
Recess Ø D ₁	5.6 mm
Overhang length L ₁ incl. recess	19 mm
Shank Ø D _s	6 mm
Overall length L	57 mm
Flute length L _c	13 mm
Direction of infeed	horizontal

Shank	DIN 6535 HA to h6
Tolerance nominal \varnothing	f8
Balance quality with shank	G 2.5 with HA
Helix angle	45 degrees
Corner chamfer angle	90 degrees
Coating	TiAlN
Tool material	Solid carbide
Standard	Manufacturer's standard
Type	N
Helix angle characteristic	unequal spacing
Spacing of the cutters	unequal spacing
Milling application	High-precision 90° mono milling tools
Cutting width a_e for milling operation	0.05×D for side milling
Through-coolant	no
Colour ring	green
Type of product	End / face mill

User data

	Suitability	V_c	ISO code
Steel < 500 N/mm ²	suitable	250 m/min	P
Steel < 750 N/mm ²	suitable	200 m/min	P
Steel < 900 N/mm ²	suitable	175 m/min	P
Steel < 1100 N/mm ²	suitable	145 m/min	P
Steel < 1400 N/mm ²	suitable	120 m/min	P
Steel < 55 HRC	suitable only under restricted conditions	50 m/min	H
INOX < 900 N/mm ²	suitable	100 m/min	M
INOX > 900 N/mm ²	suitable only under restricted conditions	80 m/min	M

GG(G)	suitable only under restricted conditions	220 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