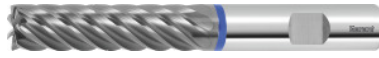


Garant

Solid carbide milling cutter with chip separators TPC, TiAlN, Ø f8 DC: 6mm



Order data

| | |
|--------------|---------------|
| Order number | 203104 6 |
| GTIN | 4045197814654 |
| Item class | 11X |

Description

Version:

High-performance milling cutter with **irregular cutter spacing** and **irregular helical pitch**. Optimised bending strength due to the use of ultra-fine grain substrates. Offset chip separators.

Advantage:

Long cutters even with small tool diameters.

Note:

h_{max} : The values stated in the table are h_{max} maximum values.

$a_{e max} = 0.05 \times D$ for TPC machining.

Tolerance nominal Ø: f8

No. of teeth Z: 7

Helix angle: 40°

Direction of infeed: horizontal and oblique

Shank: DIN 6535 HB to h6

Balance quality with shank: G 2.5 with HB

No. of teeth Z: 7

Flute length L_c : 24 mm

Overall length L: 66 mm

Shank Ø D_s : 6 mm

Corner chamfer width at 45°: 0.12 mm

Average chip thickness h_{max} for TPC milling in INOX < 900 N/mm²: 0.029 mm

Technical description

| | |
|---------------------|------------------------|
| Direction of infeed | horizontal and oblique |
| Flute length L_c | 24 mm |

| | |
|--|-------------------------|
| No. of teeth Z | 7 |
| Overall length L | 66 mm |
| Balance quality with shank | G 2.5 with HB |
| Tolerance nominal \varnothing | f8 |
| Shank $\varnothing D_s$ | 6 mm |
| Corner chamfer width at 45° | 0.12 mm |
| Shank | DIN 6535 HB to h6 |
| Cutting edge $\varnothing D_c$ | 6 mm |
| Helix angle | 40° |
| Average chip thickness h_{max} for TPC milling in INOX < 900 N/mm ² | 0.029 mm |
| Corner chamfer angle | 45° |
| Coating | TiAlN |
| Tool material | Solid carbide |
| Standard | Manufacturer's standard |
| Type | N |
| Helix angle characteristic | unequal spacing |
| Spacing of the cutters | unequal spacing |
| Cutting width a_e for milling operation | 0.05×D |
| Through-coolant | no |
| Machining strategy | TPC |
| Colour ring | blue |
| Type of product | End / face mill |

User data

| | Suitability | V_c | ISO code |
|-------------------------------|-------------|-----------|----------|
| Steel < 500 N/mm ² | suitable | 320 m/min | P |
| Steel < 750 N/mm ² | suitable | 290 m/min | P |
| Steel < 900 N/mm ² | suitable | 260 m/min | P |

| | | | |
|--------------------------------|---|-----------|---|
| Steel < 1100 N/mm ² | suitable | 200 m/min | P |
| INOX < 900 N/mm ² | suitable | 220 m/min | M |
| INOX > 900 N/mm ² | suitable | 160 m/min | M |
| wet maximum | Suitable | | |
| wet minimum | Suitable only under restricted conditions | | |
| Air | suitable | | |