Garant

# Solid carbide milling cutter HPC, ZOX, ∅ f8 DC: 6mm

## Order data

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|---|---|
| Order number | 202251 6 |
| GTIN | 4045197538574 |
| Item class | 11X |

## Description

**Version:**
Sturdy roughing end mill **without** knuckle profile.
With strong core, **special chip breaker recesses** and **large polished flutes.**
**Application:**
For roughing milling with high demands on the component surface.
**Note:**
**NEW GENERATION AVAILABLE!**
**Recommended successor product is No. 202017.**

## Technical description

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| Cutting edge ∅ $D_C$ | 6 mm |
| Corner chamfer width at 45° | 0.2 mm |
| Overhang length $L_1$ incl. recess | 42 mm |
| Shank form | HA |
| Feed $f_z$ for side milling in short-chipping aluminium | 0.08 mm |
| Recess ∅ $D_1$ | 5.7 mm |
| No. of teeth Z | 3 |
| Feed $f_z$ for slot milling in short-chipping aluminium | 0.06 mm |
| Shank ∅ $D_s$ | 6 mm |
| Overall length L | 80 mm |
| Flute length $L_c$ | 10 mm |

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| Direction of infeed | horizontal, oblique and vertical |
| Shank | DIN 6535 HA to h6 |
| Tolerance nominal ∅ | f8 |
| Balance quality with shank | G 2.5 with HA |
| Helix angle | 45 degrees |
| Corner chamfer angle | 45 degrees |
| Coating | ZOX |
| Tool material | Solid carbide |
| Standard | Manufacturer's standard |
| Type | W |
| 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 | yellow |
| Type of product | End / face mill |

## User data

| | Suitability | $V_c$ | ISO code |
|---|---|---|---|
| Aluminium | suitable only under restricted conditions | 250 m/min | N |
| Aluminium (short chipping) | suitable | 240 m/min | N |
| Alu > 10% Si | suitable | 120 m/min | N |
| CuZn | suitable | 120 m/min | N |
| wet maximum | suitable | | |
| wet minimum | suitable only under restricted conditions | | |

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| dry | suitable only under restricted conditions |
| Air | suitable only under restricted conditions |

## Services

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| Shank grinding Type HB | 129100 HB |