

**Garant**
**Solid carbide end mill with internal coolant supply HPC, ZOx, Ø f8 DC: 3mm**

**Order data**

Order number	202553 3
GTIN	4045197454379
Item class	11X

**Description**
**Version:**

Sturdy roughing end mills **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.

**Technical description**

Shank form	HA
Recess Ø D <sub>1</sub>	2.7 mm
Overhang length L <sub>1</sub> incl. recess	10 mm
Feed f <sub>z</sub> for side milling in short-chipping aluminium	0.045 mm
Cutting edge Ø D <sub>c</sub>	3 mm
Feed f <sub>z</sub> for slot milling in short-chipping aluminium	0.035 mm
Corner chamfer width at 45°	0.1 mm
No. of teeth Z	4
Shank Ø D <sub>s</sub>	6 mm
Overall length L	57 mm
Flute length L <sub>c</sub>	6 mm
Direction of infeed	horizontal, oblique and vertical
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	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	0.5×D for side milling
Cutting width $a_e$ for milling operation	Full slot cutting depth 1×D
Through-coolant	yes
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	500 m/min	N
Aluminium (short chipping)	suitable	480 m/min	N
Alu > 10% Si	suitable	240 m/min	N
Hybrids	suitable only under restricted conditions	m/min	N
CuZn	Suitable	240 m/min	N
wet maximum	suitable		
wet minimum	suitable		

dry	suitable only under restricted conditions
Air	suitable only under restricted conditions
<b>Services</b>	
Shank grinding Type HB	129100 HB