

**Garant**
**Solid carbide milling cutter, TiAlN, Ø e8 DC: 6mm**

**Order data**

Order number	202555 6
GTIN	4045197117434
Item class	11X

**Description**
**Version:**

Double relief ground side clearance angle.  
 Through-coolant: no  
 Tolerance nominal Ø: e8  
 No. of teeth Z: 4  
 Helix angle: 30°  
 Direction of infeed: horizontal, oblique and vertical  
 Shank: DIN 6535 HB to h6  
 No. of teeth Z: 4  
 Flute length  $L_c$ : 10 mm  
 Overall length L: 46 mm  
 Shank Ø  $D_s$ : 6 mm  
 Shank form: HB  
 Corner chamfer width at 45°: 0.07 mm

**Technical description**

No. of teeth Z	4
Cutting edge Ø $D_c$	6 mm
Feed $f_z$ for slot milling in steel < 900 N/mm <sup>2</sup>	0.03 mm
Corner chamfer width at 45°	0.07 mm
Shank form	HB
Feed $f_z$ for side milling in steel < 900 N/mm <sup>2</sup>	0.033 mm

Shank $\varnothing D_s$	6 mm
Overall length L	46 mm
Flute length $L_c$	10 mm
Direction of infeed	horizontal, oblique and vertical
Shank	DIN 6535 HB to h6
Tolerance nominal $\varnothing$	e8
Helix angle	30 °
Corner chamfer angle	45 °
Coating	TiAlN
Tool material	Solid carbide
Standard	Manufacturer's standard
Type	N
Cutting width $a_e$ for milling operation	0.3xD for side milling
Cutting width $a_e$ for milling operation	Full slot cutting depth 1xD
Through-coolant	no
Colour ring	without
Type of product	End / face mill

## User data

	Suitability	$V_c$	ISO code
Aluminium (short chipping)	suitable only under restricted conditions	280 m/min	N
Alu > 10% Si	suitable only under restricted conditions	200 m/min	N
Steel < 500 N/mm <sup>2</sup>	suitable	120 m/min	P
Steel < 750 N/mm <sup>2</sup>	suitable	105 m/min	P
Steel < 900 N/mm <sup>2</sup>	suitable	100 m/min	P
Steel < 1100 N/mm <sup>2</sup>	suitable	70 m/min	P
Steel < 1400 N/mm <sup>2</sup>	suitable	60 m/min	P
Steel < 55 HRC	suitable	35 m/min	H

INOX < 900 N/mm <sup>2</sup>	suitable	80 m/min	M
INOX > 900 N/mm <sup>2</sup>	suitable only under restricted conditions	60 m/min	M
GG(G)	suitable	90 m/min	K
Uni	suitable		
wet maximum	suitable		
wet minimum	Suitable only under restricted conditions		
dry	suitable		
Air	Suitable		

### Services

Shank recess Type FRST

209900 FRST