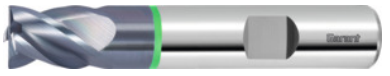
Data sheet

Garant

# GARANT Steel solid carbide milling cutter HPC, TiAlN, ∅ f8 DC: 6mm



## Order data

| | |
|---|---|
| Order number | 203053 6 |
| GTIN | 4069515028363 |
| Item class | 11Z |

## Description

**Version:**
For **roughing and finishing.** For use in unstable machining processes and for machining complex components.
Up to 1×D into solid material **at very high feed rates** with smooth cutting action.
At maximum machining depths, ensure compliance with the ratio dimension $L_C$ (cutting length) / ∅ $D_C$ (cutting ∅)!
**Advantage:**
Optimised flute form, eccentric relief ground, wide chip space.
**Note:**
**Successor product to No. 203031.**

## Technical description

| | |
|---|---|
| No. of teeth Z | 4 |
| Direction of infeed | horizontal, oblique and vertical |
| Shank ∅ $D_s$ | 6 mm |
| Tolerance nominal ∅ | f8 |
| Feed $f_z$ for side milling in steel < 900 N/mm$^2$ | 0.05 mm |
| Helix angle | 38 degrees |
| Shank | DIN 6535 HB |
| Overall length L | 54 mm |
| Feed $f_z$ for slot milling in steel < 900 N/mm$^2$ | 0.04 mm |

| | |
|---|---|
| Corner chamfer width at 45° | 0.12 mm |
| Flute length $L_c$ | 10 mm |
| Cutting edge ∅ $D_C$ | 6 mm |
| Corner chamfer angle | 45 degrees |
| Series | Master Steel |
| Coating | TiAlN |
| Tool material | Solid carbide |
| Standard | DIN 6527 |
| Type | N |
| Helix angle characteristic | unequal spacing |
| Spacing of the cutters | unequal spacing |
| Cutting width $a_e$ for milling operation | Full slot cutting depth 1×D |
| Cutting width $a_e$ for milling operation | 0.5×D for side milling |
| Through-coolant | no |
| Machining strategy | HPC |
| Colour ring | green |
| Type of product | End / face mill |

## User data

| | Suitability | $V_c$ | ISO code |
|---|---|---|---|
| Steel < 500 N/mm² | suitable | 250 m/min | P |
| Steel < 750 N/mm² | suitable | 200 m/min | P |
| Steel < 900 N/mm² | suitable | 180 m/min | P |
| Steel < 1100 N/mm² | suitable | 160 m/min | P |
| INOX < 900 N/mm² | suitable | 70 m/min | M |
| INOX > 900 N/mm² | suitable | 50 m/min | M |
| GG(G) | suitable | 120 m/min | K |
| Uni | suitable | | |
| wet maximum | suitable | | |

| | |
|---|---|
| wet minimum | suitable only under restricted conditions |
| dry | suitable |
| Air | suitable |