

**Garant**
**Solid carbide end mill HPC, DLC, Ø f8 DC: 6mm**

**Order data**

Order number	202552 6
GTIN	4045197948250
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.

**Technical description**

Feed $f_z$ for side milling in short-chipping aluminium	0.09 mm
Recess $\varnothing D_1$	5.5 mm
Feed $f_z$ for slot milling in short-chipping aluminium	0.07 mm
Shank $\varnothing D_s$	6 mm
Corner chamfer width at 45°	0.2 mm
Cutting edge $\varnothing D_c$	6 mm
Shank	DIN 6535 HA to h6
No. of teeth Z	4
Direction of infeed	horizontal, oblique and vertical
Overhang length $L_1$ incl. recess	24 mm
Shank form	HA
Helix angle	45 degrees
Tolerance nominal $\varnothing$	f8

Overall length L	62 mm
Flute length L <sub>c</sub>	18 mm
Corner chamfer angle	45 degrees
Coating	DLC
Tool material	Solid carbide
Standard	Manufacturer's standard
Type	W
Helix angle characteristic	unequal spacing
Spacing of the cutters	unequal spacing
Cutting width a <sub>e</sub> for milling operation	0.3×D for side milling
Through-coolant	no
Machining strategy	HPC
Colour ring	yellow
Type of product	End / face mill

## User data

	Suitability	V <sub>c</sub>	ISO code
Aluminium	Suitable	480 m/min	N
Aluminium (short chipping)	suitable	440 m/min	N
Alu > 10% Si	suitable	400 m/min	N
PMMA acrylic	Suitable	200 m/min	N
PE-HD	Suitable	160 m/min	N
PA 66	Suitable	200 m/min	N
PEEK	Suitable	150 m/min	N
PF 31	Suitable	130 m/min	N
PVDF GF20	suitable	180 m/min	N
POM GF25	Suitable	160 m/min	N
PA 66 GF30	suitable	150 m/min	N

PEEK GF30	suitable	130 m/min	N
PTFE CF25	suitable	160 m/min	N
Hybrids	suitable only under restricted conditions	m/min	N
Honeycomb sandwich	suitable only under restricted conditions	300 m/min	N
Cu	Suitable	160 m/min	N
CuZn	Suitable	200 m/min	N
wet maximum	suitable		
wet minimum	suitable		
dry	suitable only under restricted conditions		
Air	Suitable		
<b>Services</b>			

Shank grinding Type HB

129100 HB