

Garant

GARANT Master Steel SlotMachine solid carbide roughing end mill HPC / TPC, TiAlN, Ø d11 DC: 6mm



Order data

Order number	205554 6
GTIN	4045197959935
Item class	11X

Description

Version:

With a new-type knurled profile, optimised for higher feed rates. Improved cutting edge protection thanks to slight edge honing. Tremendous bending strength due to the use of ultra-fine grain substrate.

Advantage:

The tool geometry produces particularly tightly rolled swarf that is discharged via flat chip breaker recesses. As a result, the tool maintains an extremely stable core.

Plunge angle of up to 10° possible thanks to generous recess on the front face.

Application:

For roughing machining.

Problem-solver for TPC machining.

Technical description

Cutting edge Ø D _c	6 mm
Helix angle	42 degrees
Flute length L _c	18 mm
Shank Ø D _s	6 mm
Corner chamfer width at 45°	0.3 mm
Feed f _z for slot milling in steel < 900 N/mm ²	0.03 mm
Feed f _z for side milling in steel < 900 N/mm ²	0.04 mm
Overall length L	62 mm

Direction of infeed	horizontal, oblique and vertical
No. of teeth Z	5
Tolerance nominal \varnothing	d11
Shank	DIN 6535 HB to h6
Recess $\varnothing D_1$	5.6 mm
Overhang length L_1 incl. recess	25 mm
Corner chamfer angle	45 degrees
Series	Master Steel
Coating	TiAlN
Tool material	Solid carbide
Standard	Manufacturer's standard
Milling profile	NR
Spacing of the cutters	unequal spacing
Cutting width a_e for milling operation	Full slot cutting depth $1 \times D$
Cutting width a_e for milling operation	$0.4 \times D$ for side milling
Through-coolant	no
Machining strategy	HPC
Machining strategy	TPC
Colour ring	green
Type of product	End / face mill

User data

	Suitability	V_c	ISO code
Steel < 500 N/mm ²	suitable	200 m/min	P
Steel < 750 N/mm ²	suitable	180 m/min	P
Steel < 900 N/mm ²	suitable	160 m/min	P
Steel < 1100 N/mm ²	suitable	140 m/min	P
Steel < 1400 N/mm ²	suitable	110 m/min	P
INOX < 900 N/mm ²	suitable	50 m/min	M

INOX > 900 N/mm ²	suitable	35 m/min	M
GG(G)	suitable	200 m/min	K
Uni	suitable		
wet maximum	suitable		
wet minimum	suitable only under restricted conditions		
dry	suitable		
Air	suitable		