

**Garant**
**GARANT Master Alu solid carbide milling cutter HPC, DLC, Ø DC: 6mm**

**Order data**

Order number	202512 6
GTIN	4062406238858
Item class	11X

**Description**
**Version:**
**Extra sharp cutting edges.**

Dimensions similar to DIN6527.

For roughing and finishing. Up to 2xD into solid material at very high feed rates and smooth cutting action.

With the latest generation of **DLC coating sp<sup>2</sup>**.

**Note:**

**Successor product to No. 202515.**

**Technical description**

Tolerance nominal Ø	h6
Feed $f_z$ for side milling in short-chipping aluminium	0.08 mm
Shank	DIN 6535 HA to h6
Cutting edge Ø $D_c$	6 mm
Helix angle	38 degrees
Recess Ø $D_1$	5.5 mm
Direction of infeed	horizontal, oblique and vertical
Overhang length $L_1$ incl. recess	21 mm
Overall length L	57 mm
Shank Ø $D_s$	6 mm

Feed $f_z$ for slot milling in short-chipping aluminium	0.06 mm
No. of teeth Z	4
Flute length $L_c$	16 mm
Corner chamfer angle	90 degrees
Series	Master Alu
Coating	DLC
Tool material	Solid carbide
Standard	DIN 6527
Type	W
Cutting width $a_e$ for milling operation	Full slot cutting depth $1 \times D$
Cutting width $a_e$ for milling operation	$0.25 \times D$ for side milling
Through-coolant	no
Machining strategy	HPC
Colour ring	yellow
Type of product	End / face mill

## User data

	Suitability	$V_c$	ISO code
Aluminium	suitable	550 m/min	N
Aluminium (short chipping)	suitable	500 m/min	N
Alu > 10% Si	suitable	450 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
Honeycomb sandwich	suitable	300 m/min	N
Cu	Suitable	160 m/min	N
CuZn	Suitable	200 m/min	N
wet maximum	suitable		
wet minimum	suitable only under restricted conditions		
dry	suitable only under restricted conditions		
Air	suitable		

### Services

Shank grinding Type HB

129100 HB