

## Garant

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



#### Order data

Order number	205556 6
GTIN	4062406112110
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.

##### Note:

Particularly long neck recess for avoiding interference contours.

With conically increasing recess to guarantee stability at long overhangs.

#### Technical description

Cutting edge Ø D <sub>c</sub>	6 mm
Tolerance nominal Ø	d11
Helix angle	42 degrees
No. of teeth Z	5
Shank	DIN 6535 HB to h6
Direction of infeed	horizontal, oblique and vertical
Overall length L	80 mm

Shank $\varnothing D_s$	6 mm
Overhang length $L_1$ incl. recess	42 mm
Corner chamfer width at $45^\circ$	0.3 mm
Feed $f_z$ for side milling in steel $< 900 \text{ N/mm}^2$	0.04 mm
Flute length $L_c$	13 mm
minimum shank recess dia. $D_5$	5.4 mm
maximum shank recess dia. $D_6$	5.8 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	$0.3 \times D$ 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 $< 500 \text{ N/mm}^2$	suitable	180 m/min	P
Steel $< 750 \text{ N/mm}^2$	suitable	170 m/min	P
Steel $< 900 \text{ N/mm}^2$	suitable	150 m/min	P
Steel $< 1100 \text{ N/mm}^2$	suitable	130 m/min	P
Steel $< 1400 \text{ N/mm}^2$	suitable	100 m/min	P
INOX $< 900 \text{ N/mm}^2$	suitable	45 m/min	M
INOX $> 900 \text{ N/mm}^2$	suitable	30 m/min	M

GG(G)	suitable	180 m/min	K
Uni	suitable		
wet maximum	suitable		
wet minimum	suitable only under restricted conditions		
dry	suitable		
Air	suitable		