

**Garant**
**Solid carbide milling cutter TPC, uncoated, Ø h6 DC: 6mm**

**Order data**

Order number	202283 6
GTIN	4045197977229
Item class	11X

**Description**
**Version:**

**Eccentric relief ground**, additionally **polish ground** in the flutes for **outstanding chip evacuation** in long-chipping aluminium workpieces.

With double chip-breaker for exemplary chip formation.

**Note:**

$a_{e\ max} = 0.1 \times D$  for TPC machining.

$h_{max}$ : The values stated in the table are maximum values.

**Technical description**

Overhang length $L_1$ incl. recess	36 mm
Recess $\varnothing D_1$	5.7 mm
Shank	DIN 6535 HA to h6
No. of teeth Z	3
Cutting edge $\varnothing D_c$	6 mm
Direction of infeed	horizontal, oblique and vertical
Tolerance nominal $\varnothing$	h6
Shank form	HA
Balance quality with shank	G 2.5 with HA
Average chip thickness $h_{max}$ for TPC milling in short-chipping aluminium	0.027 mm
Helix angle	45 degrees

Overall length L	76 mm
Corner chamfer width at 45°	0.2 mm
Shank $\varnothing D_s$	6 mm
Flute length $L_c$	31 mm
Corner chamfer angle	45 degrees
Coating	uncoated
Tool material	Solid carbide
Standard	Manufacturer's standard
Type	W
Helix angle characteristic	unequal spacing
Cutting width $a_e$ for milling operation	$0.1 \times D$
Through-coolant	no
Machining strategy	TPC
Colour ring	yellow
Type of product	End / face mill

## User data

	Suitability	$V_c$	ISO code
Aluminium	Suitable	130 m/min	N
Aluminium (short chipping)	suitable	100 m/min	N
Alu > 10% Si	suitable	85 m/min	N
PMMA acrylic	suitable	125 m/min	N
PE-HD	Suitable	90 m/min	N
PA 66	Suitable	100 m/min	N
PEEK	suitable	80 m/min	N
PF 31	Suitable	70 m/min	N
Honeycomb sandwich	suitable only under restricted conditions	100 m/min	N

Cu	Suitable	70 m/min	N
CuZn	Suitable	90 m/min	N
wet maximum	suitable		
wet minimum	suitable		
dry	suitable only under restricted conditions		
Air	suitable only under restricted conditions		

**Services**

Shank grinding Type HB

129100 HB