

Garant**GARANT Master Steel SlotMachine solid carbide roughing end mill with through-coolant HPC, TiAlN, Ø d11 DC: 6 mm****Order data**

Order number	205551 6
GTIN	4062406111151
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.

Feed rate per tooth up to 0.1 mm up to a depth of 2xD (in the slot milled from solid).

With **internal coolant supply** for reliable swarf evacuation.

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, particularly suitable for full-slot machining.

Tolerance nominal Ø: d11

No. of teeth Z: 5

Helix angle: 42 degrees

Direction of infeed: horizontal and oblique

Shank: DIN 6535 HB to h6

No. of teeth Z: 5

Flute length L_c: 13 mm

Overhang length L₁ incl. recess: 19 mm

Recess Ø D₁: 5.6 mm

Overall length L: 57 mm

Shank Ø D_s: 6 mm

Technical description

Corner chamfer width at 45°	0.3 mm
Flute length L_c	13 mm
Overhang length L_1 incl. recess	19 mm
Tolerance nominal $\varnothing$	d11
Recess $\varnothing D_1$	5.6 mm
Overall length L	57 mm
Cutting edge $\varnothing D_c$	6 mm
Feed f_z for slot milling in steel < 900 N/mm ²	0.035 mm
Feed f_z for side milling in steel < 900 N/mm ²	0.045 mm
Direction of infeed	horizontal and oblique
No. of teeth Z	5
Helix angle	42 degrees
Shank	DIN 6535 HB to h6
Shank $\varnothing D_s$	6 mm
Corner chamfer angle	45 degrees
Series	GARANT Master Steel
Coating	TiAlN
Tool material	Solid carbide
Standard	DIN 6527
Milling profile	NR
Spacing of the cutters	unequal spacing
Cutting width a_e for milling operation	0.4×D for side milling
Cutting width a_e for milling operation	0.05×D for copy milling
Through-coolant	yes
Machining strategy	HPC
Colour ring	green
Type of product	End mill

