

M6800

High Shear Square Shoulder Milling Cutters

Specifically engineered to stream line your end milling program!

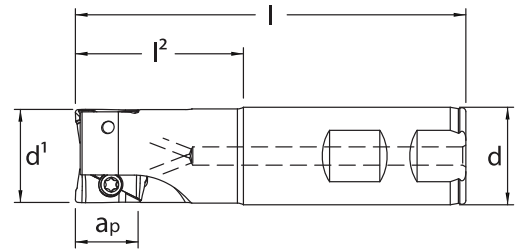
Applications

- Pocket milling
- Circular milling
- Profile milling
- Face and shoulder milling
- Slot milling
- Z axis milling

Features

- Roughing and finishing with one milling cutter
- Machining of steel, stainless steel, cast iron and difficult to machine materials
- Highly precise pressed indexable inserts
- 2 insert sizes offering maximum DOC of .394" and .618" respectively
- Widia's best grades: TN6405, TN6425, TN6430
- Outstanding Z-Axis milling capabilities
- True 90° square shoulders
- Easy handling and clamping system, with only one screw
- Through coolant cutter bodies

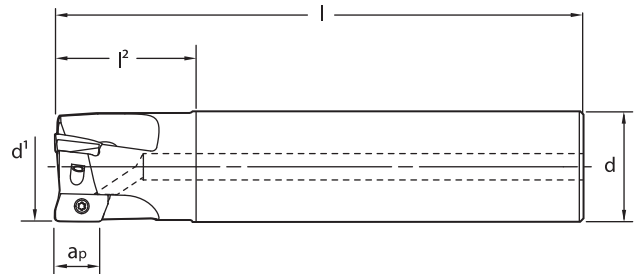
**New
Addition!**



Standard Length End Mills with Coolant Through

Designation	d ¹	d	l	l ²	Max. ap ¹	flutes	Insert	Insert Screw	Wrench
M6800M-D062W062-L300-Z2	.625	.625	3.00	1.004	.394	2	BDMT-11T3__ER-ML BDMT-11T3__ER-MS BDGT-11T30__FR-AL	214.61.209	214.80.866
M6800M-D075W075-L325-Z3	.750	.750	3.25	1.201	.394	3			
M6800M-D100W075-L325-Z3	1.000	.750	3.25	1.161	.394	3			
M6800M-D100W100-L375-Z3	1.000	1.000	3.75	1.280	.394	3	BDMT-1704__ER-ML BDMT-1704__ER-MS BDGT-1704__FR-AL	214.61.210	214.80.824
M6800LX-D100W100-L375-Z2	1.000	1.000	3.75	1.437	.618	2			
M6800LX-D125W125-L400-Z3	1.250	1.250	4.00	1.595	.618	3			
M6800LX-D150W125-L435-Z4	1.500	1.250	4.35	1.988	.618	4			

Remember to use COPASLIP® anti-seize compound on all insert screws



Extended Length Cylindrical Shank End Mills with Coolant Through

Designation	d ¹	d	l	l ²	Max. ap ¹	flutes	Insert	Insert Screw	Wrench
M6800LX-D100C100-L630-Z2	1.000	1.000	6.30	4.200	.618	2	BDMT-1704__ER-ML BDMT-1704__ER-MS BDGT-1704__FR-AL	214.61.210	214.80.824
M6800LX-D150C125L945-Z2	1.500	1.250	9.45	2.579	.618	2			

Remember to use COPASLIP® anti-seize compound on all insert screws

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High Shear Square Shoulder Milling Cutters



- .394" - .618" depth-of-cut capability!
- Aggressive ramping rates!
- Superior surface finish!
- True 90° shoulders!
- High rpm capabilities!

Standard Series Face Mills

Designation	d ¹	d	d ⁶	h	Max. ap1	flutes	Insert	Insert Screw	Wrench
M6800M-D150B075-H157-Z5	1.500	.750	1.26	1.57	.394	5	BDMT-11T3__ER-ML BDMT-11T3__ER-MS BDGT-11T30_FR-AL	214.61.209	214.80.866
M6800M-D200B075-H157-Z5	2.000	.750	1.60	1.57	.394	5			
M6800M-D250B075-H157-Z6	2.500	.750	1.60	1.57	.394	6			
M6800M-D300B100-H196-Z7	3.000	1.000	1.92	1.96	.394	7			
M6800M-D400B150-H248-Z9	4.000	1.500	2.62	2.48	.394	9			
M6800LX-D200B075-H158-Z4	2.000	.750	1.60	1.58	.618	4	BDMT-1704__ER-ML BDMT-1704__ER-MS BDGT-1704__FR-AL	214.61.210	214.80.824
M6800LX-D250B075-H158-Z5	2.500	.750	1.60	1.58	.618	5			
M6800LX-D300B100-H197-Z6	3.000	1.000	1.92	1.97	.618	6			
M6800LX-D400B150-H248-Z7	4.000	1.500	2.62	2.48	.618	7			

Remember to use COPASLIP® anti-seize compound on all insert screws

M6800 Test Report

M6800 Test Report		WIDIA	COMPETITOR
Cutter:	M6800M ϕ .750"	Cutting Speed (sfm):	290
Insert:	BDMT-11T308ER-ML	feed per tooth:	.005"
Grade:	TN6430	axial cutting depth:	.197"
Operation:	Contour milling	parts / index:	23 vs 10
Material:	ASTM A236 steel, grade D	width of cut:	.750"
Tool Life Increase: 130%			

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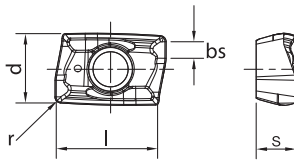
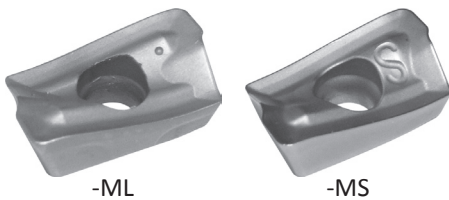
BDMT

ML - Light edge preparation, reduced cutting force. For finishing applications with highest degree of accuracy. For cast iron, steel and alloy steel.

MS - Sharpest edge, reduced cutting force up to 20%. For low carbon and stainless steels.

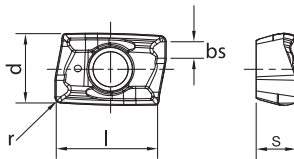
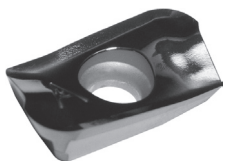
BDGT

AL - Peripheral ground with polished rake face optimized for aluminum applications.



M6800 Inserts

Designation	l	d	s	bs	r	M6800 Inserts			THR-S			Coated			Uncoated			Cermet				
						TN6405	TN6425	TN6430														
BDMT-11T304ER-ML	.433	.262	.150	.070	.016	●		●														
BDMT-11T308ER-ML		.263		.055	.031	●		●														
BDMT-11T312ER-ML		.263		.040	.047	●		●														
BDMT-11T316ER-ML		.264		.021	.063	●		●														
BDMT-11T320ER-ML		.265		--	.079	●		●														
BDMT-11T331ER-ML		.266		--	.122	●		●														
BDMT-170404ER-ML	.699	.378	.193	.090	.016	●		●														
BDMT-170408ER-ML				.074	.031	●		●														
BDMT-170412ER-ML				.059	.047	●		●														
BDMT-170416ER-ML				.041	.063	●		●														
BDMT-170420ER-ML		.379		.025	.079	●		●														
BDMT-170431ER-ML		.380		--	.122	●		●														
BDMT-11T304ER-MS	.433	.262	.150	.071	.016		●	●														
BDMT-11T308ER-MS		.263		.055	.031		●	●														
BDMT-170404ER-MS	.669	.378	.193	.090	.016		●	●														
BDMT-170408ER-MS				.074	.031		●	●														



M6800 Aluminum Inserts

Designation	l	d	s	bs	r	M6800 Aluminum Inserts			THR-S			Coated			Uncoated			Cermet					
						TN6405	TN6425	TN6430															
BDGT-11T302FR-AL	.433	.261	.153	.079	.008																	●	
BDGT-11T304FR-AL		.263		.071	.016																		●
BDGT-11T308FR-AL		.263		.055	.031																		●
BDGT-170404FR-AL	.669	.378	.201	.091	.016																		●
BDGT-170408FR-AL		.379		.075	.031																		●
BDGT-170420FR-AL		.380		.024	.083																		●
BDGT-170431FR-AL		.382		--	.136																		●