

Garant
GARANT Master Steel solid carbide roughing end mill HPC, TiAlN, Ø f8 DC: 25mm

Order data

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|--------------|---------------|
| Order number | 203035 25 |
| GTIN | 4045197718846 |
| Item class | 11X |

Description
Version:

For **roughing and finishing**.

Up to 1.5×D into solid material **at very high feed rates** with smooth cutting action.

Advantage:

Optimised flute form, eccentric relief ground, wide chip space.

Technical description

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|--|----------------------------------|
| Overhang length L_1 incl. recess | 80 mm |
| Corner chamfer width at 45° | 0.5 mm |
| Feed f_z for slot milling in steel < 900 N/mm ² | 0.12 mm |
| Feed f_z for side milling in steel < 900 N/mm ² | 0.16 mm |
| Recess Ø D_1 | 24.5 mm |
| Cutting edge Ø D_c | 25 mm |
| No. of teeth Z | 4 |
| Shank Ø D_s | 25 mm |
| Overall length L | 136 mm |
| Flute length L_c | 68 mm |
| Direction of infeed | horizontal, oblique and vertical |
| Shank | DIN 6535 HB to h6 |

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|---|-----------------------------|
| Tolerance nominal \varnothing | f8 |
| Helix angle | 38 degrees |
| Corner chamfer angle | 45 degrees |
| Series | Master Steel |
| Coating | TiAlN |
| Tool material | Solid carbide |
| Standard | DIN 6527 |
| Type | N |
| Helix angle characteristic | unequal spacing |
| Spacing of the cutters | unequal spacing |
| Cutting width a_e for milling operation | 0.3×D for side milling |
| Cutting width a_e for milling operation | Full slot cutting depth 1×D |
| Through-coolant | no |
| Machining strategy | HPC |
| Colour ring | green |
| Type of product | End / face mill |

User data

| | Suitability | V_c | ISO code |
|--------------------------------|---|-----------|----------|
| Steel < 500 N/mm ² | suitable | 260 m/min | P |
| Steel < 750 N/mm ² | suitable | 240 m/min | P |
| Steel < 900 N/mm ² | suitable | 190 m/min | P |
| Steel < 1100 N/mm ² | suitable | 180 m/min | P |
| Steel < 1400 N/mm ² | suitable only under restricted conditions | 150 m/min | P |
| INOX < 900 N/mm ² | suitable | 80 m/min | M |
| INOX > 900 N/mm ² | suitable | 70 m/min | M |
| GG(G) | suitable | 250 m/min | K |
| Uni | suitable | | |

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|-------------|---|
| wet maximum | suitable |
| wet minimum | suitable only under restricted conditions |
| dry | suitable |
| Air | suitable |