Garant

GARANT Master Steel SlotMachine solid carbide roughing end mill HPC, TiAlN, ⌀ d11 DC: 8mm

Order data

Order number	205556 8
GTIN	4062406112127
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

Flute length L_c	21 mm
Feed f_z for side milling in steel < 900 N/mm^2	0.05 mm
Overhang length L_1 incl. recess	62 mm
maximum shank recess dia. D_6	7.8 mm
Shank	DIN 6535 HB to h6
minimum shank recess dia. D_5	7.2 mm
Direction of infeed	horizontal, oblique and vertical

Corner chamfer width at 45°	0.4 mm
Shank ⌀ D_s	8 mm
Tolerance nominal ⌀	d11
Helix angle	42 degrees
Cutting edge ⌀ D_C	8 mm
No. of teeth Z	5
Overall length L	100 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×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 N/mm²	suitable	180 m/min	P
Steel < 750 N/mm²	suitable	170 m/min	P
Steel < 900 N/mm²	suitable	150 m/min	P
Steel < 1100 N/mm²	suitable	130 m/min	P
Steel < 1400 N/mm²	suitable	100 m/min	P
INOX < 900 N/mm²	suitable	45 m/min	M
INOX > 900 N/mm²	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		