

## Garant

### GARANT Master INOX solid carbide milling cutter HPC / TPC, TiAlN, Ø h10 DC: 25mm



#### Order data

|              |               |
|--------------|---------------|
| Order number | 203007 25     |
| GTIN         | 4045197777317 |
| Item class   | 11X           |

#### Description

##### Version:

For **roughing and finishing**.

HPC milling cutter with **newly developed high-performance coating** for **outstanding tool life** and **optimum metal removal rate** in a very wide range of stainless steels. **Greater oxidation resistance** and **high-temperature hardness**.

Can be used at **high cutting speeds**, particularly suitable even for TOOLOX®.

##### Advantage:

Particularly low vibration running.

#### Technical description

|  |                                  |
|--|----------------------------------|
| No. of teeth Z   | 4                                |
| Overall length L   | 121 mm                           |
| Feed $f_z$ for side milling in INOX > 900 N/mm <sup>2</sup>            | 0.08 mm                          |
| Cutting edge Ø $D_c$   | 25 mm                            |
| Tolerance nominal Ø  | h10                              |
| Recess Ø $D_1$   | 24.5 mm                          |
| Flute length $L_c$   | 45 mm                            |
| Direction of infeed  | horizontal, oblique and vertical |
| Overhang length $L_1$ incl. recess                                     | 66 mm                            |
| Feed $f_z$ for slot milling in stainless steel > 900 N/mm <sup>2</sup> | 0.07 mm                          |

|   |                             |
|---|-----------------------------|
| Corner chamfer width at 45°               | 0.35 mm                     |
| Shank                                     | DIN 6535 HB to h6           |
| Shank $\varnothing D_s$                   | 25 mm                       |
| Helix angle                               | 40 degrees                  |
| Corner chamfer angle                      | 45 degrees                  |
| Series                                    | Master INOX                 |
| 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 | 0.1×D                       |
| Cutting width $a_e$ for milling operation | Full slot cutting depth 1×D |
| Through-coolant                           | no                          |
| Machining strategy                        | TPC                         |
| Machining strategy                        | HPC                         |
| Colour ring                               | blue                        |
| Type of product                           | End / face mill             |

## User data

|                                | Suitability | $V_c$     | ISO code |
|--------------------------------|-------------|-----------|----------|
| Steel < 500 N/mm <sup>2</sup>  | suitable    | 250 m/min | P        |
| Steel < 750 N/mm <sup>2</sup>  | suitable    | 230 m/min | P        |
| Steel < 900 N/mm <sup>2</sup>  | suitable    | 200 m/min | P        |
| Steel < 1100 N/mm <sup>2</sup> | suitable    | 180 m/min | P        |
| Steel < 1400 N/mm <sup>2</sup> | suitable    | 115 m/min | P        |
| Steel < 50 HRC                 | suitable    | 80 m/min  | H        |
| INOX < 900 N/mm <sup>2</sup>   | suitable    | 110 m/min | M        |

|                              |   |          |   |
|------------------------------|---|----------|---|
| INOX > 900 N/mm <sup>2</sup> | suitable                                  | 90 m/min | M |
| wet maximum                  | suitable                                  |          |   |
| wet minimum                  | suitable                                  |          |   |
| dry                          | Suitable only under restricted conditions |          |   |
| Air                          | suitable                                  |          |   |