

Garant
GARANT Master Steel PickPocket solid carbide roughing end mill HPC, TiAlN, Ø f8 DC: 13,7mm

Order data

Order number	202404 13,7
GTIN	4045197781260
Item class	11X

Description
Version:

 For **roughing and finishing**

With corner radii similar to torus cutters.

 Up to 1×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

Flute length L_c	26 mm
Overall length L	83 mm
Shank $\varnothing D_s$	14 mm
Feed f_z for side milling in steel < 900 N/mm ²	0.1 mm
Recess $\varnothing D_1$	13.5 mm
Shank	DIN 6535 HB to h6
Overhang length L_1 incl. recess	36 mm
Cutting edge $\varnothing D_c$	13.7 mm
Tolerance nominal \varnothing	f8
Feed f_z for slot milling in steel < 900 N/mm ²	0.08 mm
Direction of infeed	horizontal, oblique and vertical

No. of teeth Z	3
Helix angle	38 degrees
Corner rounding r_v	0.69 mm
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	0.4×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		

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