

Garant
GARANT Master INOX solid carbide milling cutter HPC / TPC, TiAlN, Ø h10 DC: 3mm

Order data

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|--------------|---------------|
| Order number | 203007 3 |
| GTIN | 4045197781161 |
| 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

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|------------------------------------------------------------------------|----------------------------------|
| Feed f_z for side milling in INOX > 900 N/mm ² | 0.015 mm |
| Direction of infeed | horizontal, oblique and vertical |
| Flute length L_c | 8 mm |
| Feed f_z for slot milling in stainless steel > 900 N/mm ² | 0.012 mm |
| Overhang length L_1 incl. recess | 20 mm |
| Tolerance nominal Ø | h10 |
| Shank Ø D_s | 6 mm |
| Cutting edge Ø D_c | 3 mm |
| Corner chamfer width at 45° | 0.15 mm |
| Overall length L | 57 mm |

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|-------------------------------------------|-----------------------------|
| No. of teeth Z | 4 |
| Shank | DIN 6535 HB to h6 |
| Recess $\varnothing D_1$ | 2.8 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 ² | suitable | 250 m/min | P |
| Steel < 750 N/mm ² | suitable | 230 m/min | P |
| Steel < 900 N/mm ² | suitable | 200 m/min | P |
| Steel < 1100 N/mm ² | suitable | 180 m/min | P |
| Steel < 1400 N/mm ² | suitable | 115 m/min | P |
| Steel < 50 HRC | suitable | 80 m/min | H |
| INOX < 900 N/mm ² | suitable | 110 m/min | M |

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