

## Garant

### GARANT Master INOX solid carbide milling cutter HPC / TPC, TiAlN, Ø h10 DC: 6mm



#### Order data

Order number	202997 6
GTIN	4062406231583
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

Flute length $L_c$	13 mm
Overall length $L$	57 mm
Helix angle	40 degrees
Feed $f_z$ for side milling in INOX > 900 N/mm <sup>2</sup>	0.03 mm
Feed $f_z$ for slot milling in stainless steel > 900 N/mm <sup>2</sup>	0.025 mm
Direction of infeed	horizontal, oblique and vertical
No. of teeth $Z$	4
Corner chamfer width at 45°	0.1 mm
Recess Ø $D_1$	5.6 mm
Shank Ø $D_s$	6 mm

Cutting edge $\varnothing D_c$	6 mm
Shank	DIN 6535 HB to h6
Overhang length $L_1$ incl. recess	23 mm
Tolerance nominal $\varnothing$	h10
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	Full slot cutting depth $1 \times D$
Cutting width $a_e$ for milling operation	$0.1 \times D$
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		