Garant

GARANT Master INOX solid carbide milling cutter HPC / TPC, TiAlN, Ø h10 DC: 8mm

Order data

Order number	202997 8
GTIN	4062406231590
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
Shank Ø D_s	8 mm
Direction of infeed	horizontal, oblique and vertical
Flute length L_c	19 mm
Recess Ø D_1	7.5 mm
Overall length L	63 mm
Tolerance nominal Ø	h10
Shank	DIN 6535 HB to h6
Feed f_z for side milling in INOX > 900 N/mm^2	0.04 mm
Corner chamfer width at 45°	0.1 mm

Helix angle	40 degrees
Overhang length L_1 incl. recess	29 mm
Feed f_z for slot milling in stainless steel > 900 N/mm^2	0.025 mm
Cutting edge $\varnothing$ D_c	8 mm
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×D
Cutting width a_e for milling operation	0.1×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/mm²	suitable	90 m/min	M
wet maximum	suitable		
wet minimum	suitable		
dry	Suitable only under restricted conditions		
Air	suitable		