

## Garant

### GARANT Master INOX M solid carbide milling cutter HPC, TiAlN, Ø e8 DC: 6mm



#### Order data

Order number	202986 6
GTIN	4062406242305
Item class	11X

#### Description

##### Version:

Milling cutter with newly **developed high-performance coating** for **outstanding tool working life** and **optimum metal removal rates** in a wide range of stainless steels. Can be used at high **cutting speeds**, e.g. in duplex steels.

##### Note:

**Successor product to No. 202993.**

#### Technical description

Shank	DIN 6535 HB to h6
Overhang length $L_1$ incl. recess	16 mm
Recess $\varnothing D_1$	5.8 mm
Helix angle	42 degrees
Direction of infeed	horizontal, oblique and vertical
No. of teeth Z	4
Flute length $L_c$	10 mm
Overall length L	54 mm
Shank $\varnothing D_s$	6 mm
Cutting edge $\varnothing D_c$	6 mm
Feed $f_z$ for side milling in INOX > 900 N/mm <sup>2</sup>	0.05 mm

Tolerance nominal $\varnothing$	e8
Feed $f_z$ for slot milling in stainless steel $> 900 \text{ N/mm}^2$	0.04 mm
Corner rounding $r_v$	0.1 mm
Series	Master INOX
Coating	TiAlN
Tool material	solid carbide
Standard	Manufacturer's standard
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	Full slot cutting depth $1 \times D$
Through-coolant	no
Machining strategy	HPC
Colour ring	blue
Type of product	End / face mill

## User data

	Suitability	$V_c$	ISO code
Steel $< 500 \text{ N/mm}^2$	suitable	250 m/min	P
Steel $< 750 \text{ N/mm}^2$	suitable	230 m/min	P
Steel $< 900 \text{ N/mm}^2$	suitable	200 m/min	P
Steel $< 1100 \text{ N/mm}^2$	suitable	180 m/min	P
Steel $< 1400 \text{ N/mm}^2$	suitable	170 m/min	P
TOOLOX 33	suitable	115 m/min	H
TOOLOX 44	suitable	80 m/min	H
INOX $< 900 \text{ N/mm}^2$	suitable	100 m/min	M
INOX $> 900 \text{ N/mm}^2$	suitable	90 m/min	M

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