

**Garant**
**GARANT Master INOX M solid carbide milling cutter HPC, TiAlN, Ø e8 DC: 3mm**

**Order data**

Order number	202986 3
GTIN	4062406242275
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**

Feed $f_z$ for side milling in INOX > 900 N/mm <sup>2</sup>	0.03 mm
Overall length L	50 mm
No. of teeth Z	4
Tolerance nominal Ø	e8
Direction of infeed	horizontal, oblique and vertical
Shank Ø $D_s$	6 mm
Feed $f_z$ for slot milling in stainless steel > 900 N/mm <sup>2</sup>	0.02 mm
Cutting edge Ø $D_c$	3 mm
Shank	DIN 6535 HB to h6
Helix angle	42 degrees
Flute length $L_c$	5 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 $1 \times D$
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Through-coolant	no
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	170 m/min	P
TOOLOX 33	suitable	115 m/min	H
TOOLOX 44	suitable	80 m/min	H
INOX < 900 N/mm <sup>2</sup>	suitable	100 m/min	M
INOX > 900 N/mm <sup>2</sup>	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