

Garant
GARANT Master INOX M solid carbide milling cutter HPC, TiAlN, Ø e8 DC: 20mm

Order data

| | |
|--------------|---------------|
| Order number | 202986 20 |
| GTIN | 4062406242367 |
| 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

| | |
|---|-------------------|
| Overhang length L_1 incl. recess | 40 mm |
| Feed f_z for slot milling in stainless steel $> 900 \text{ N/mm}^2$ | 0.1 mm |
| Flute length L_c | 26 mm |
| Recess $\varnothing D_1$ | 19.5 mm |
| Feed f_z for side milling in INOX $> 900 \text{ N/mm}^2$ | 0.12 mm |
| Cutting edge $\varnothing D_c$ | 20 mm |
| No. of teeth Z | 4 |
| Shank $\varnothing D_s$ | 20 mm |
| Shank | DIN 6535 HB to h6 |
| Helix angle | 42 degrees |
| Tolerance nominal \varnothing | e8 |

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|---|--------------------------------------|
| Overall length L | 92 mm |
| Direction of infeed | horizontal, oblique and vertical |
| Corner rounding r_v | 0.2 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 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 | 170 m/min | P |
| TOOLOX 33 | suitable | 115 m/min | H |
| TOOLOX 44 | suitable | 80 m/min | H |
| INOX < 900 N/mm ² | suitable | 100 m/min | M |
| INOX > 900 N/mm ² | suitable | 90 m/min | M |

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