

Garant
GARANT Master INOX M solid carbide milling cutter HPC / TPC, TiAlN, Ø e8 DC: 8Mmm

Order data

Order number	202989 8M
GTIN	4062406245030
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. 203009.

Technical description

Tolerance nominal Ø	e8
Overall length L	68 mm
No. of teeth Z	4
Feed f_z for side milling in INOX > 900 N/mm ²	0.07 mm
Shank	DIN 6535 HB to h6
Cutting edge Ø D_c	8 mm
Shank Ø D_s	8 mm
Recess Ø D_1	7.7 mm
Feed f_z for slot milling in stainless steel > 900 N/mm ²	0.06 mm
Helix angle	42 degrees
Flute length L_c	24 mm

Overhang length L_1 incl. recess	30 mm
Direction of infeed	horizontal, oblique and vertical
Corner rounding r_v	0.15 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	$0.03 \times D$ for copy milling
Cutting width a_e for milling operation	$0.1 \times D$
Through-coolant	no
Machining strategy	HPC
Machining strategy	TPC
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
Uni	suitable only under restricted conditions		
wet maximum	suitable		
wet minimum	suitable		
dry	Suitable only under restricted conditions		
Air	suitable		