Garant

GARANT Master INOX M solid carbide milling cutter HPC / TPC, TiAlN, ⌀ e8 DC: 20mm

Order data

Order number	202989 20
GTIN	4062406245122
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

Direction of infeed	horizontal, oblique and vertical
Helix angle	42 degrees
Overall length L	104 mm
Recess ⌀ D_1	19.5 mm
Overhang length L_1 incl. recess	52 mm
Shank ⌀ D_s	20 mm
Tolerance nominal ⌀	e8
No. of teeth Z	4
Feed f_z for slot milling in stainless steel > 900 N/mm^2	0.1 mm
Feed f_z for side milling in INOX > 900 N/mm^2	0.12 mm
Cutting edge ⌀ D_C	20 mm

Shank	DIN 6535 HB to h6
Flute length L_c	41 mm
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×D
Cutting width a_e for milling operation	0.03×D for copy milling
Cutting width a_e for milling operation	0.1×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/mm²	suitable	250 m/min	P
Steel < 750 N/mm²	suitable	230 m/min	P
Steel < 900 N/mm²	suitable	200 m/min	P
Steel < 1100 N/mm²	suitable	180 m/min	P
Steel < 1400 N/mm²	suitable	170 m/min	P
TOOLOX 33	suitable	115 m/min	H
TOOLOX 44	suitable	80 m/min	H
INOX < 900 N/mm²	suitable	100 m/min	M

INOX > 900 N/mm²	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		