

Garant

GARANT Master Steel solid carbide mini milling cutter HPC, TiAlN, Ø e8 DC: 1,8mm



Order data

Order number	202289 1,8
GTIN	4062406271114
Item class	11X

Description

Version:

Extra short cutter for maximum stability. **Shank length to DIN** for improved support of the tool in the holder. This significantly increases the tool life.

Save the regrinding costs: It is cheaper to use a carbide mini slot drill to the limit of wear and throw it away, than to regrind it.

Tool for **general-purpose machining**.

Note:

HB shanks are available at the same price as HA.

For **HB** shanks use order **no. 202291**.

Technical description

Direction of infeed	horizontal, oblique and vertical
Feed f_z for side milling in steel < 900 N/mm ²	0.006 mm
Cutting edge Ø D_c	1.8 mm
Flute length L_c	3 mm
Helix angle	30 degrees
Shank Ø D_s	3 mm
Feed f_z for slot milling in steel < 900 N/mm ²	0.005 mm
No. of teeth Z	3
Tolerance nominal Ø	e8

Shank	DIN 6535 HA to h6
Overall length L	38 mm
Corner chamfer angle	90 degrees
Series	Master Steel
Coating	TiAlN
Tool material	Solid carbide
Standard	Manufacturer's standard
Type	N
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	green
Type of product	End / face mill

User data

	Suitability	V_c	ISO code
Aluminium (short chipping)	suitable only under restricted conditions	290 m/min	N
Alu > 10% Si	suitable only under restricted conditions	240 m/min	N
Steel < 500 N/mm ²	suitable	140 m/min	P
Steel < 750 N/mm ²	suitable	120 m/min	P
Steel < 900 N/mm ²	suitable	100 m/min	P
Steel < 1100 N/mm ²	suitable	70 m/min	P
Steel < 1400 N/mm ²	suitable	50 m/min	P
INOX < 900 N/mm ²	suitable	90 m/min	M
INOX > 900 N/mm ²	suitable	70 m/min	M
Ti > 850 N/mm ²	suitable	40 m/min	S

GG(G)	suitable	85 m/min	K
Uni	suitable		
wet maximum	suitable		
wet minimum	suitable only under restricted conditions		
dry	suitable		
Air	suitable		