

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

**Order data**

Order number	202295 1,1
GTIN	4062406271282
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. 202297**.

**Technical description**

Corner chamfer width at 45°	0.02 mm
No. of teeth Z	3
Shank	DIN 6535 HA to h6
Overall length L	38 mm
Tolerance nominal Ø	e8
Feed $f_z$ for side milling in steel < 900 N/mm <sup>2</sup>	0.006 mm
Cutting edge Ø $D_c$	1.1 mm
Flute length $L_c$	2 mm
Shank Ø $D_s$	3 mm

Helix angle	45 degrees
Feed $f_z$ for slot milling in steel < 900 N/mm <sup>2</sup>	0.005 mm
Direction of infeed	horizontal, oblique and vertical
Corner chamfer angle	45 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 1xD
Cutting width $a_e$ for milling operation	Full slot cutting depth 1xD
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 <sup>2</sup>	suitable	140 m/min	P
Steel < 750 N/mm <sup>2</sup>	suitable	120 m/min	P
Steel < 900 N/mm <sup>2</sup>	suitable	100 m/min	P
Steel < 1100 N/mm <sup>2</sup>	suitable	70 m/min	P
Steel < 1400 N/mm <sup>2</sup>	suitable	50 m/min	P
INOX < 900 N/mm <sup>2</sup>	suitable	90 m/min	M
INOX > 900 N/mm <sup>2</sup>	suitable	70 m/min	M

Ti > 850 N/mm <sup>2</sup>	suitable only under restricted conditions	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		