Garant

GARANT Master Steel solid carbide mini milling cutter HPC, TiAlN, ∅ e8 DC: 1,4mm

Order data

Order number	202295 1,4
GTIN	4062406271312
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

Direction of infeed	horizontal, oblique and vertical
Flute length L_c	3 mm
Feed f_z for side milling in steel < 900 N/mm^2	0.006 mm
Corner chamfer width at 45°	0.02 mm
Feed f_z for slot milling in steel < 900 N/mm^2	0.005 mm
Overall length L	38 mm
Shank ∅ D_s	3 mm
Cutting edge ∅ D_C	1.4 mm
No. of teeth Z	3

Tolerance nominal ∅	e8
Shank	DIN 6535 HA to h6
Helix angle	45 degrees
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 1×D
Cutting width a_e for milling operation	Full slot cutting depth 1×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/mm²	suitable	140 m/min	P
Steel < 750 N/mm²	suitable	120 m/min	P
Steel < 900 N/mm²	suitable	100 m/min	P
Steel < 1100 N/mm²	suitable	70 m/min	P
Steel < 1400 N/mm²	suitable	50 m/min	P
INOX < 900 N/mm²	suitable	90 m/min	M
INOX > 900 N/mm²	suitable	70 m/min	M

Ti > 850 N/mm²	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		