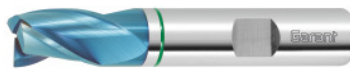


**Garant**
**GARANT Master Steel solid carbide mini-milling cutter HPC, TiAlN, Ø e8 DC: 2mm**

**Order data**

|              |               |
|--------------|---------------|
| Order number | 202291 2      |
| GTIN         | 4062406271527 |
| 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**.

**Technical description**

|  |                                  |
|--|----------------------------------|
| Tolerance nominal $\varnothing$                              | e8                               |
| Cutting edge $\varnothing D_c$                               | 2 mm                             |
| Feed $f_z$ for side milling in steel < 900 N/mm <sup>2</sup> | 0.012 mm                         |
| Overall length L   | 50 mm                            |
| Shank $\varnothing D_s$                                      | 6 mm                             |
| Shank  | DIN 6535 HB to h6                |
| Helix angle  | 30 degrees                       |
| Direction of infeed  | horizontal, oblique and vertical |
| Flute length $L_c$   | 4 mm                             |
| Feed $f_z$ for slot milling in steel < 900 N/mm <sup>2</sup> | 0.01 mm                          |

|   |                                      |
|---|--------------------------------------|
| No. of teeth Z                            | 3                                    |
| Corner chamfer angle                      | 90 degrees                           |
| Series                                    | Master Steel                         |
| Coating                                   | TiAlN                                |
| Tool material                             | Solid carbide                        |
| Standard                                  | Manufacturer's standard              |
| Type                                      | N                                    |
| Helix angle characteristic                | 1                                    |
| 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 <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<br>restricted conditions |          |   |
| dry         | suitable                                     |          |   |
| Air         | suitable                                     |          |   |