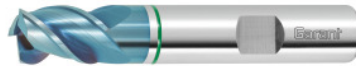


Garant
GARANT Master Steel solid carbide mini-milling cutter HPC, TiAlN, Ø e8 DC: 8mm

Order data

| | |
|--------------|---------------|
| Order number | 202297 8 |
| GTIN | 4062406272142 |
| 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

| | |
|---|----------------------------------|
| Flute length L_c | 13 mm |
| Overall length L | 55 mm |
| Feed f_z for side milling in steel $< 900 \text{ N/mm}^2$ | 0.045 mm |
| Feed f_z for slot milling in steel $< 900 \text{ N/mm}^2$ | 0.04 mm |
| Shank | DIN 6535 HB to h6 |
| No. of teeth Z | 3 |
| Helix angle | 45 degrees |
| Direction of infeed | horizontal, oblique and vertical |
| Cutting edge $\varnothing D_c$ | 8 mm |
| Corner chamfer width at 45° | 0.05 mm |
| Shank $\varnothing D_s$ | 8 mm |

| | |
|---|--------------------------------------|
| Tolerance nominal \varnothing | e8 |
| 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 $1 \times D$ |
| 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 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 |