Garant

GARANT Master Steel solid carbide mini-milling cutter HPC, TiAlN, ∅ 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 N/mm^2	0.045 mm
Feed f_z for slot milling in steel < 900 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 ∅ D_C	8 mm
Corner chamfer width at 45°	0.05 mm
Shank ∅ D_s	8 mm

Tolerance nominal ∅	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×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