Garant

GARANT Master Steel SlotMachine solid carbide roughing end mill HPC / TPC, TiAlN, ⌀ d11 DC: 8mm

Order data

Order number	205555 8
GTIN	4062406275631
Item class	11X

Description

Version:
With a new-type knurled profile, optimised for higher feed rates. Improved cutting edge protection thanks to slight edge honing. Tremendous bending strength due to the use of ultra-fine grain substrate.
Advantage:
The tool geometry produces particularly tightly rolled swarf that is discharged via flat chip breaker recesses. As a result, the tool maintains an extremely stable core.
Application:
For roughing machining.
Problem-solver for TPC machining.

Technical description

Flute length L_c	32 mm
No. of teeth Z	5
Tolerance nominal ⌀	d11
Cutting edge ⌀ D_C	8 mm
Corner chamfer angle	45 degrees
Helix angle	42 degrees
Shank ⌀ D_s	8 mm
Corner chamfer width at 45°	0.4 mm
Shank	DIN 6535 HB to h6

Direction of infeed	horizontal, oblique and vertical
Overall length L	74 mm
Feed f_z for side milling in steel < 900 N/mm^2	0.06 mm
Feed f_z for slot milling in steel < 900 N/mm^2	0.04 mm
Series	Master Steel
Coating	TiAlN
Tool material	Solid carbide
Standard	Manufacturer's standard
Milling profile	NR
Spacing of the cutters	unequal spacing
Cutting width a_e for milling operation	0.2×D for side milling
Through-coolant	no
Machining strategy	HPC
Machining strategy	TPC
Colour ring	green
Type of product	End / face mill

User data

	Suitability	V_c	ISO code
Steel < 500 N/mm^2	suitable	180 m/min	P
Steel < 750 N/mm^2	suitable	170 m/min	P
Steel < 900 N/mm^2	suitable	150 m/min	P
Steel < 1100 N/mm^2	suitable	130 m/min	P
Steel < 1400 N/mm^2	suitable	100 m/min	P
INOX < 900 N/mm^2	suitable	45 m/min	M
INOX > 900 N/mm^2	suitable	30 m/min	M
GG(G)	suitable	180 m/min	K
Uni	suitable		
wet maximum	suitable		

wet minimum	suitable only under restricted conditions
dry	suitable
Air	suitable