Garant

GARANT Master INOX M SlotMachine solid carbide roughing end mill HPC, TiAlN, ⌀ d11 DC: 5mm

Order data

Order number	205448 5
GTIN	4062406275488
Item class	11X

Description

Version:
With a **new-type knuckle form profile**, optimised for higher feed rates in INOX. Improved cutting edge protection thanks to slight edge honing. **Tremendous bending strength** due to the use of **ultra-fine grain substrate**. Number of teeth tailored to performance and process reliability.
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, particularly suitable for full-slot machining.
Recommendation:
To ensure reliable working, particularly for full slot milling, use arbors with **4 cooling channel bores**.

Technical description

No. of teeth Z	4
Corner chamfer width at 45°	0.15 mm
Feed f_z for slot milling in stainless steel > 900 N/mm^2	0.015 mm
Shank	DIN 6535 HB to h6
Direction of infeed	horizontal, oblique and vertical
Helix angle	40 degrees

Feed f_z for side milling in INOX > 900 N/mm²	0.02 mm
Flute length L_c	9 mm
Cutting edge ⌀ D_C	5 mm
Corner chamfer angle	45 degrees
Overall length L	54 mm
Shank ⌀ D_s	6 mm
Tolerance nominal ⌀	d11
Series	Master INOX
Coating	TiAlN
Tool material	Solid carbide
Standard	DIN 6527
Milling profile	NR
Cutting width a_e for milling operation	Full slot cutting depth 1×D
Cutting width a_e for milling operation	0.5×D for side milling
Through-coolant	no
Machining strategy	HPC
Colour ring	blue
Type of product	End / face mill

User data

	Suitability	V_c	ISO code
Steel < 500 N/mm²	suitable only under restricted conditions	150 m/min	P
Steel < 750 N/mm²	suitable	140 m/min	P
Steel < 900 N/mm²	suitable	120 m/min	P
Steel < 1100 N/mm²	suitable only under restricted conditions	110 m/min	P
Steel < 1400 N/mm²	suitable only under restricted conditions	100 m/min	P
INOX < 900 N/mm²	suitable	90 m/min	M

INOX > 900 N/mm²	suitable	80 m/min	M
Uni	suitable only under restricted conditions		
wet maximum	suitable		
wet minimum	suitable only under restricted conditions		
Air	Suitable only under restricted conditions		