

## Garant

### GARANT Master INOX M SlotMachine solid carbide roughing end mill HPC, TiAlN, Ø d11 DC: 20mm



## Order data

Order number	205450 20
GTIN	4062406276126
Item class	11X

## Description

### Version:

With a **new type of knuckle form 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**. Number of cutters selected for 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

Overall length L	104 mm
Feed $f_z$ for slot milling in stainless steel > 900 N/mm <sup>2</sup>	0.06 mm
Helix angle	40 degrees
Feed $f_z$ for side milling in INOX > 900 N/mm <sup>2</sup>	0.07 mm
Recess Ø D <sub>1</sub>	18.5 mm
Overhang length L <sub>1</sub> incl. recess	52 mm
Corner chamfer angle	45 degrees

Shank	DIN 6535 HB to h6
Corner chamfer width at 45°	0.4 mm
No. of teeth Z	5
Direction of infeed	horizontal, oblique and vertical
Cutting edge $\varnothing D_c$	20 mm
Tolerance nominal $\varnothing$	d11
Flute length $L_c$	38 mm
Shank $\varnothing D_s$	20 mm
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 1xD
Cutting width $a_e$ for milling operation	Full slot cutting depth 1xD
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/mm <sup>2</sup>	suitable only under restricted conditions	150 m/min	P
Steel < 750 N/mm <sup>2</sup>	suitable	140 m/min	P
Steel < 900 N/mm <sup>2</sup>	suitable	120 m/min	P
Steel < 1100 N/mm <sup>2</sup>	suitable	110 m/min	P
Steel < 1400 N/mm <sup>2</sup>	suitable	100 m/min	P
INOX < 900 N/mm <sup>2</sup>	suitable	90 m/min	M

INOX > 900 N/mm <sup>2</sup>	suitable	80 m/min	M
Uni	suitable		
wet maximum	suitable		
wet minimum	suitable only under restricted conditions		
Air	suitable		