

**Garant**
**GARANT Master Titan HSS-PM roughing end mill HPC, TiAlN, Ø k10 DC / R1: 32/2,0mm**

**Order data**

Order number	192945 32/2,0
GTIN	4062406300456
Item class	11Z

**Description**
**Version:**

Innovative knurled profile and optimised flute geometry for a evacuating a high volume of chips at very high process reliability. Increased tool life due to precise alignment of the through-coolant with the cutting edges.

**Advantage:**

New type of tool material; problem solver under unstable machining conditions.

**Technical description**

No. of teeth Z	6
Shank	DIN 6535 HB to h6
Overall length L	186 mm
Recess Ø D <sub>1</sub>	31 mm
Tolerance nominal Ø	k10
Shank Ø D <sub>s</sub>	32 mm
Direction of infeed	horizontal, oblique and vertical
Cutting edge Ø D <sub>c</sub>	32 mm
Feed f <sub>z</sub> for side milling in INOX > 900 N/mm <sup>2</sup>	0.05 mm
Feed f <sub>z</sub> for side milling in titanium > 850 N/mm <sup>2</sup>	0.05 mm
Helix angle	40 degrees

Overhang length $L_1$ incl. recess	123 mm
Flute length $L_c$	106 mm
Corner radius $R_1$	2 mm
Series	Master Titan
Coating	TiAlN
Tool material	HSS PM
Standard	DIN 844
Milling profile	HR
Helix angle characteristic	unequal spacing
Spacing of the cutters	unequal spacing
Cutting width $a_e$ for milling operation	$0.3 \times D$ for side milling
Through-coolant	no
Machining strategy	HPC
Colour ring	pink
Type of product	End / face mill

## User data

	Suitability	$V_c$	ISO code
INOX < 900 N/mm <sup>2</sup>	suitable	30 m/min	M
INOX > 900 N/mm <sup>2</sup>	suitable	28 m/min	M
Ti > 850 N/mm <sup>2</sup>	suitable	28 m/min	S
wet maximum	suitable		