

Garant
GARANT Master Steel SlotMachine solid carbide roughing end mill HPC / TPC, TiAlN, Ø d11 DC: 12mm

Order data

Order number	205557 12
GTIN	4062406377052
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. Plunge angle of up to 10° possible thanks to generous recess on the front face.

Application:

For roughing machining.

Problem-solver for TPC machining.

Technical description

Flute length L_c	60 mm
Corner chamfer angle	45 degrees
Tolerance nominal \varnothing	d11
Cutting edge $\varnothing D_c$	12 mm
Shank $\varnothing D_s$	12 mm
Feed f_z for side milling in steel < 900 N/mm ²	0.08 mm
Helix angle	42 degrees
Direction of infeed	horizontal, oblique and vertical

Shank	DIN 6535 HB to h6
Overall length L	112 mm
No. of teeth Z	5
Corner chamfer width at 45°	0.6 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	TPC
Machining strategy	HPC
Colour ring	green
Type of product	End / face mill

User data

	Suitability	V_c	ISO code
Steel < 500 N/mm ²	suitable	160 m/min	P
Steel < 750 N/mm ²	suitable	150 m/min	P
Steel < 900 N/mm ²	suitable	130 m/min	P
Steel < 1100 N/mm ²	suitable	110 m/min	P
Steel < 1400 N/mm ²	suitable	80 m/min	P
INOX < 900 N/mm ²	suitable	40 m/min	M
INOX > 900 N/mm ²	suitable	25 m/min	M
GG(G)	suitable	160 m/min	K
Uni	suitable		
wet maximum	suitable		

wet minimum	suitable only under restricted conditions
dry	suitable
Air	suitable