

## Garant

### GARANT Master INOX M SlotMachine solid carbide roughing end mill HPC, TiAlN, Ø d11 DC: 8mm



## Order data

Order number	205454 8
GTIN	4062406380687
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.

**Problem-solver** for **TPC machining**. Ideal for automated production as the risk of chip accumulations in the machine is largely prevented.

### 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**.

### Recommendation:

To ensure reliable working, particularly for full slot milling, use arbors with **4 cooling channel bores**.

### Note:

$h_{max}$ : The values stated in the table are maximum values.

$ae_{max} = 0.05 \times D$  for TPC machining.

## Technical description

Corner chamfer angle	45 degrees
Tolerance nominal Ø	d11
Overall length L	79 mm
Corner chamfer width at 45°	0.2 mm

Overhang length $L_1$ incl. recess	40 mm
Shank	DIN 6535 HB to h6
Direction of infeed	horizontal, oblique and vertical
Helix angle	40 degrees
Average chip thickness $h_{max}$ for TPC milling in INOX < 900 N/mm <sup>2</sup>	0.038 mm
No. of teeth Z	4
Shank $\varnothing D_s$	8 mm
Recess $\varnothing D_1$	7.4 mm
Cutting edge $\varnothing D_c$	8 mm
Flute length $L_c$	33 mm
Series	Master INOX
Coating	TiAlN
Tool material	Solid carbide
Standard	Manufacturer's standard
Milling profile	NF
Cutting width $a_e$ for milling operation	0.05×D
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	130 m/min	P
Steel < 750 N/mm <sup>2</sup>	suitable	120 m/min	P
Steel < 900 N/mm <sup>2</sup>	suitable	100 m/min	P
Steel < 1100 N/mm <sup>2</sup>	suitable only under restricted conditions	95 m/min	P

Steel < 1400 N/mm <sup>2</sup>	suitable only under restricted conditions	85 m/min	P
INOX < 900 N/mm <sup>2</sup>	suitable	75 m/min	M
INOX > 900 N/mm <sup>2</sup>	suitable	70 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		