Garant

GARANT Master INOX M SlotMachine solid carbide roughing end mill HPC, TiAlN, ⌀ d11 DC: 6mm

Order data

Order number	205454 6
GTIN	4062406380670
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

Shank	DIN 6535 HB to h6
Cutting edge ⌀ D_C	6 mm
Overall length L	66 mm
Average chip thickness h_{max} for TPC milling in INOX < 900 N/mm^2	0.029 mm

Overhang length L_1 incl. recess	32 mm
Shank ⌀ D_s	6 mm
Corner chamfer width at 45°	0.15 mm
Corner chamfer angle	45 degrees
Tolerance nominal ⌀	d11
Flute length L_c	25 mm
Recess ⌀ D_1	5.6 mm
Helix angle	40 degrees
No. of teeth Z	4
Direction of infeed	horizontal, oblique and vertical
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/mm²	suitable only under restricted conditions	130 m/min	P
Steel < 750 N/mm²	suitable	120 m/min	P
Steel < 900 N/mm²	suitable	100 m/min	P
Steel < 1100 N/mm²	suitable only under restricted conditions	95 m/min	P

Steel < 1400 N/mm²	suitable only under restricted conditions	85 m/min	P
INOX < 900 N/mm²	suitable	75 m/min	M
INOX > 900 N/mm²	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		