Garant

GARANT Master UNI solid carbide milling cutter HPC, TiSiN, ∅ e8 DC: 25mm

Order data

Order number	203067 25
GTIN	4062406569709
Item class	11Z

Description

Version:
For **roughing and finishing at very high feed rates** with smooth cutting action. **Newly developed geometry and high-performance coating** for outstanding production results and very long tool life with a variety of materials. Unequal spacing gives **high intrinsic stability** and smooth cutting action.
Advantage:
Especially for **MTC (Multi Task Cutting)** use on the new generation of turning / milling centres.

Technical description

Shank ∅ D_s	25 mm
Feed f_z for side milling in INOX > 900 N/mm^2	0.09 mm
Feed f_z for slot milling in steel < 900 N/mm^2	0.12 mm
Recess ∅ D_1	24.5 mm
Overall length L	136 mm
Feed f_z for side milling in steel < 900 N/mm^2	0.16 mm
Shank	DIN 6535 HB to h6
Corner rounding r_v	0.3 mm
Helix angle	42 degrees
Feed f_z for slot milling in stainless steel > 900 N/mm^2	0.08 mm
Overhang length L_1 incl. recess	80 mm

No. of teeth Z	4
Cutting edge ⌀ D_C	25 mm
Flute length L_c	68 mm
Direction of infeed	horizontal, oblique and vertical
Tolerance nominal ⌀	e8
Series	Master Uni
Coating	TiSiN
Tool material	solid carbide
Standard	Manufacturer's standard
Type	N
Helix angle characteristic	unequal spacing
Spacing of the cutters	unequal spacing
Cutting width a_e for milling operation	0.3×D for side milling
Cutting width a_e for milling operation	Full slot cutting depth 1×D
Through-coolant	no
Machining strategy	MTC
Colour ring	green
Type of product	End / face mill

User data

	Suitability	V_c	ISO code
Aluminium (short chipping)	suitable only under restricted conditions	280 m/min	N
Steel < 500 N/mm²	suitable	260 m/min	P
Steel < 750 N/mm²	suitable	240 m/min	P
Steel < 900 N/mm²	suitable	190 m/min	P
Steel < 1100 N/mm²	suitable	180 m/min	P
Steel < 1400 N/mm²	suitable	150 m/min	P
INOX < 900 N/mm²	suitable	90 m/min	M

INOX > 900 N/mm²	suitable	80 m/min	M
Ti > 850 N/mm²	suitable only under restricted conditions	40 m/min	S
GG(G)	suitable	250 m/min	K
Uni	suitable		
wet maximum	suitable		
wet minimum	suitable only under restricted conditions		
dry	suitable		
Air	suitable		