

## Garant

### GARANT Master INOX solid carbide milling cutter with chip separators TPC, TiAlN, Ø f8 DC: 12mm



#### Order data

Order number	203117 12
GTIN	4062406783679
Item class	11Z

#### Description

##### Version:

High-performance milling cutter with **irregular cutter spacing** and **irregular helical pitch**. **High process reliability** and **better chip evacuation** due to **increased flutes**. **Optimised carbide substrate** for **higher bending strength** and **extreme tool life**, even in stainless steels in the high-performance field, especially duplex. **Chip separator** positioned offset **at cutting edges**.

##### Advantage:

Lower pull-out forces due to reduced helix angle.

##### Note:

$h_{max}$ : The values stated in the table are maximum values. For finishing operations we recommend items No. 204012, 204014, 204015, 204016, 204018 and 204019.

$a_{e_{max}} = 0.1 \times D$  for TPC machining.

#### Technical description

Balance quality with shank	G 2.5 with HB
Corner chamfer width at 45°	0.24 mm
Recess Ø D <sub>1</sub>	11.8 mm
No. of teeth Z	6
Overhang length L <sub>1</sub> incl. recess	45 mm
Average chip thickness $h_{max}$ for TPC milling in INOX < 900 N/mm <sup>2</sup>	0.072 mm

Shank	DIN 6535 HB to h6
Cutting edge $\varnothing D_c$	12 mm
Tolerance nominal $\varnothing$	e8
Corner chamfer angle	45 degrees
Shank $\varnothing D_s$	12 mm
Helix angle	36 degrees
Flute length $L_c$	36 mm
Overall length $L$	93 mm
Direction of infeed	horizontal, oblique and vertical
Number of chip separators	2
Series	Master INOX
Coating	TiAlN
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	$0.1 \times D$
Through-coolant	no
Machining strategy	TPC
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	380 m/min	P
Steel < 750 N/mm <sup>2</sup>	Suitable only under restricted conditions	340 m/min	P

Steel < 900 N/mm <sup>2</sup>	Suitable only under restricted conditions	300 m/min	P
Steel < 1100 N/mm <sup>2</sup>	Suitable only under restricted conditions	230 m/min	P
INOX < 900 N/mm <sup>2</sup>	suitable	240 m/min	M
INOX > 900 N/mm <sup>2</sup>	suitable	170 m/min	M
Ti > 850 N/mm <sup>2</sup>	suitable	140 m/min	S
wet maximum	suitable		
wet minimum	Suitable only under restricted conditions		
Air	suitable		