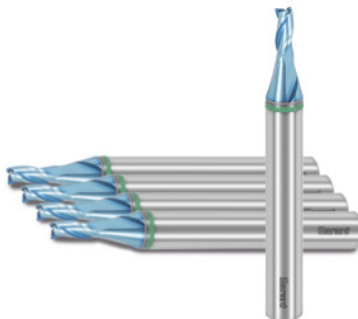


Garant
GARANT Master Steel solid carbide mini milling cutter HPC, TiAlN, Ø e8 DC: 1,8mm

Order data

Order number	GG2289 1,8
GTIN	4067263091035
Item class	GGN

Description
Version:

Extra short cutter for maximum stability. **Shank length to DIN** for improved support of the tool in the holder. This significantly increases the tool life.

Save the regrinding costs: It is cheaper to use a carbide mini slot drill to the limit of wear and throw it away, than to regrind it.

Same as No. 202289.

Technical description

Direction of infeed	horizontal, oblique and vertical
Feed f_z for side milling in steel $< 900 \text{ N/mm}^2$	0.006 mm
Cutting edge $\varnothing D_c$	1.8 mm
Shank form	HA
Corner chamfer angle	90 degrees
Overall length L	38 mm

Contents	5
Helix angle	30 degrees
Shank $\varnothing D_s$	3 mm
Flute length L_c	3 mm
No. of teeth Z	3
Feed f_z for slot milling in steel < 900 N/mm ²	0.005 mm
Shank	DIN 6535 HA to h6
Tolerance nominal \varnothing	e8
Series	Master Steel
Coating	TiAlN
Tool material	Solid carbide
Standard	Works standard
Type	N
Cutting width a_e for milling operation	0.3×D for side milling
Cutting width a_e for milling operation	0.5×D for side milling
Through-coolant	no
Machining strategy	HPC
Colour ring	green
Type of product	End / face mill

User data

	Suitability	V_c	ISO code
Aluminium (short chipping)	suitable only under restricted conditions	290 m/min	N
Alu > 10% Si	suitable only under restricted conditions	240 m/min	N
Steel < 500 N/mm ²	suitable	140 m/min	P
Steel < 750 N/mm ²	suitable	120 m/min	P
Steel < 900 N/mm ²	suitable	100 m/min	P

Steel < 1100 N/mm ²	suitable	70 m/min	P
Steel < 1400 N/mm ²	suitable	50 m/min	P
INOX < 900 N/mm ²	suitable	90 m/min	M
INOX > 900 N/mm ²	suitable	70 m/min	M
Ti > 850 N/mm ²	suitable only under restricted conditions	40 m/min	S
GG(G)	suitable	85 m/min	K
Uni	suitable		
wet maximum	suitable		
wet minimum	suitable only under restricted conditions		
dry	suitable		
Air	suitable		

Accessories

GARANT Master Steel solid carbide mini milling cutterHPC
 Ø e8 DC 1,8 mm

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