Garant

GARANT Master UNI solid carbide milling cutter HPC, TiSiN, ∅ e8 DC: 10mm

Order data

Order number	203073 10
GTIN	4067263092025
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 excellent production results with maximum tool life in various materials. **High intrinsic stability** and smooth cutting action due to unequal spacing.
Advantage:
· **Particularly low vibration running.**
· **Special flute profile, large flutes.**
· **Specially matched edge honing.**
· **Optimised substrate for hardness and toughness.**

Technical description

Helix angle	42 degrees
Recess ∅ D_1	9.7 mm
Corner rounding r_v	0.2 mm
Direction of infeed	horizontal, oblique and vertical
Overhang length L_1 incl. recess	38 mm
Tolerance nominal ∅	e8
Feed f_z for slot milling in steel < 900 N/mm^2	0.05 mm
Shank	DIN 6535 HB to h6
Feed f_z for side milling in steel < 900 N/mm^2	0.07 mm

Feed f_z for side milling in INOX > 900 N/mm²	0.04 mm
Feed f_z for slot milling in stainless steel > 900 N/mm²	0.035 mm
Cutting edge ∅ D_C	10 mm
Overall length L	80 mm
Flute length L_c	30 mm
Shank ∅ D_s	10 mm
No. of teeth Z	4
Series	Master Uni
Coating	TiSiN
Tool material	Solid carbide
Standard	Works 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	0.3×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	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		