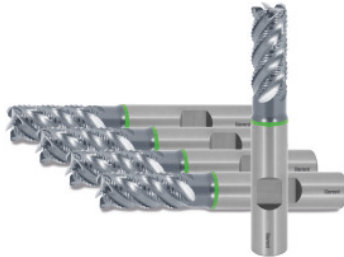


**Garant**
**GARANT Master Steel SlotMachine solid carbide roughing end mill HPC, TiAlN, Ø d11 DC: 12mm**

**Order data**

Order number	GG1050 12
GTIN	4067263134954
Item class	GGN

**Description**
**Version:**

With a new-type knurled profile, optimised for higher feed rates. Improved cutting edge protection thanks to slight edge honing. Tremendous bending strength due to the use of ultra-fine grain substrate.

Feed rate per tooth up to 0.1 mm up to a depth of  $2 \times D$  (in the slot milled from solid).

**Same as 205550.**

**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. Plunge angle of up to  $10^\circ$  possible thanks to generous recess on the front face.

**Application:**

For roughing machining, particularly suitable for full-slot machining.

**Technical description**

Feed $f_z$ for slot milling in steel $< 900 \text{ N/mm}^2$	0.065 mm
Recess $\varnothing D_1$	11.1 mm
Flute length $L_c$	26 mm

Corner chamfer angle	45 degrees
Helix angle	42 degrees
Overall length L	83 mm
Cutting edge $\varnothing D_c$	12 mm
Direction of infeed	horizontal, oblique and vertical
Feed $f_z$ for side milling in steel $< 900 \text{ N/mm}^2$	0.09 mm
Shank $\varnothing D_s$	12 mm
No. of teeth Z	5
Corner chamfer width at $45^\circ$	0.6 mm
Shank	DIN 6535 HB to h6
Overhang length $L_1$ incl. recess	36 mm
Tolerance nominal $\varnothing$	d11
Series	Master Steel
Coating	TiAlN
Tool material	Solid carbide
Standard	DIN 6527
Milling profile	NR
Spacing of the cutters	unequal spacing
Cutting width $a_e$ for milling operation	$0.3 \times D$ for side milling
Cutting width $a_e$ for milling operation	$0.3 \times D$ 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
Steel $< 500 \text{ N/mm}^2$	suitable	200 m/min	P
Steel $< 750 \text{ N/mm}^2$	suitable	180 m/min	P

Steel < 900 N/mm <sup>2</sup>	suitable	160 m/min	P
Steel < 1100 N/mm <sup>2</sup>	suitable	140 m/min	P
Steel < 1400 N/mm <sup>2</sup>	suitable	110 m/min	P
INOX < 900 N/mm <sup>2</sup>	suitable	50 m/min	M
INOX > 900 N/mm <sup>2</sup>	suitable	35 m/min	M
GG(G)	suitable	200 m/min	K
Uni	suitable		
wet maximum	suitable		
wet minimum	suitable only under restricted conditions		
dry	suitable		
Air	suitable		

## Accessories

GARANT Master Steel SlotMachine solid carbide roughing end millHPC Ø d11 DC 12 mm

205550 12