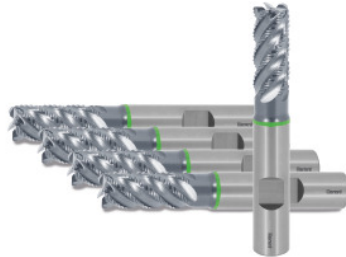


Garant

GARANT Master Steel SlotMachine solid carbide roughing end mill HPC, TiAlN, Ø d11 DC: 9mm



Order data

Order number	GG1050 9
GTIN	4067263134930
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° possible thanks to generous recess on the front face.

Application:

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

Technical description

Helix angle	42 degrees
Feed f_z for slot milling in steel $< 900 \text{ N/mm}^2$	0.045 mm
Shank	DIN 6535 HB to h6

Corner chamfer angle	45 degrees
Recess $\varnothing D_1$	8.3 mm
Flute length L_c	19 mm
Overall length L	72 mm
Tolerance nominal \varnothing	d11
Overhang length L_1 incl. recess	30 mm
Corner chamfer width at 45°	0.45 mm
Shank $\varnothing D_s$	10 mm
Cutting edge $\varnothing D_c$	9 mm
Direction of infeed	horizontal, oblique and vertical
No. of teeth Z	5
Feed f_z for side milling in steel $< 900 \text{ N/mm}^2$	0.06 mm
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 ²	suitable	160 m/min	P
Steel < 1100 N/mm ²	suitable	140 m/min	P
Steel < 1400 N/mm ²	suitable	110 m/min	P
INOX < 900 N/mm ²	suitable	50 m/min	M
INOX > 900 N/mm ²	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

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205550 9