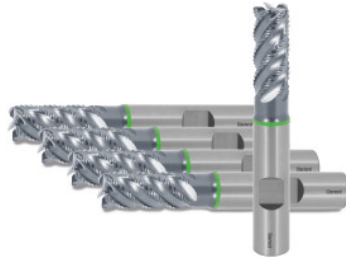


Garant**GARANT Master Steel SlotMachine solid carbide roughing end mill HPC, TiAlN, Ø d11 DC: 14mm****Order data**

| | |
|--------------|---------------|
| Order number | GG1050 14 |
| GTIN | 4067263134961 |
| 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 |
| Direction of infeed | horizontal, oblique and vertical |
| Feed f_z for slot milling in steel $< 900 \text{ N/mm}^2$ | 0.07 mm |

| | |
|---|---------------------------------|
| Corner chamfer angle | 45 degrees |
| Shank $\varnothing D_s$ | 14 mm |
| Shank | DIN 6535 HB to h6 |
| Recess $\varnothing D_1$ | 13 mm |
| Feed f_z for side milling in steel $< 900 \text{ N/mm}^2$ | 0.1 mm |
| Tolerance nominal \varnothing | d11 |
| Overhang length L_1 incl. recess | 36 mm |
| No. of teeth Z | 5 |
| Flute length L_c | 26 mm |
| Overall length L | 83 mm |
| Corner chamfer width at 45° | 0.7 mm |
| Cutting edge $\varnothing D_c$ | 14 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

GARANT Master Steel SlotMachine solid carbide roughing
end millHPC Ø d11 DC 14 mm

205550 14