

Garant**GARANT INOX SlotMachine solid carbide roughing end mill HPC, AlTiN, Ø e8
DC: 8mm****Order data**

Order number	205449 8
GTIN	4069515036924
Item class	11Z

Description**Version:**

With modified knuckle form profile, optimised flutes and state-of-the-art high-performance coating. Exceptionally well suited for roughing machining work on stainless steel materials.

Dimensions similar to DIN 6527.

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**.

Recommendation:

To ensure reliable working, particularly for full slot milling, use arbors with **4 cooling channel bores**.

Technical description

Tolerance nominal Ø	e8
Corner chamfer width at 45°	0.2 mm
Direction of infeed	horizontal, oblique and vertical
Helix angle	40 degrees
Feed f_z for side milling in INOX > 900 N/mm ²	0.05 mm
No. of teeth Z	4
Flute length L_c	21 mm
Cutting edge Ø D_c	8 mm

Data sheet

Recess $\varnothing D_1$	7.7 mm
Feed f_z for slot milling in stainless steel $> 900 \text{ N/mm}^2$	0.04 mm
Correction factor $a_{p \text{ corr}}$	1.5
Shank $\varnothing D_s$	8 mm
Overall length L	63 mm
Corner chamfer angle	45 degrees
Shank	DIN 6535 HB to h6
Overhang length L_1 incl. recess	25 mm
Coating	AlTiN
Tool material	Solid carbide
Standard	DIN 6527
Milling profile	NF
Cutting width a_e for milling operation	$0.3 \times D$ for side milling
Cutting width a_e for milling operation	$0.5 \times D$ for side milling
Through-coolant	no
Machining strategy	HPC
Colour ring	blue
Type of product	Indexable end mill

User data

	Suitability	V_c	ISO code
Steel $< 500 \text{ N/mm}^2$	suitable only under restricted conditions	170 m/min	P
Steel $< 750 \text{ N/mm}^2$	suitable only under restricted conditions	150 m/min	P
Steel $< 900 \text{ N/mm}^2$	suitable only under restricted conditions	130 m/min	P
Steel $< 1100 \text{ N/mm}^2$	suitable only under restricted conditions	120 m/min	P

Data sheet

Steel < 1400 N/mm ²	suitable only under restricted conditions	110 m/min	P
TOOLOX 33	suitable only under restricted conditions	105 m/min	H
TOOLOX 44	suitable only under restricted conditions	70 m/min	H
INOX < 900 N/mm ²	suitable	90 m/min	M
INOX > 900 N/mm ²	suitable	80 m/min	M
wet maximum	suitable		
wet minimum	suitable only under restricted conditions		
Air	suitable only under restricted conditions		