

Garant**GARANT INOX SlotMachine solid carbide roughing end mill HPC, AlTiN, Ø e8
DC: 20mm****Order data**

Order number	205449 20
GTIN	4069515036962
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

Cutting edge Ø D _c	20 mm
Feed f _z for side milling in INOX > 900 N/mm ²	0.095 mm
Flute length L _c	41 mm
Helix angle	40 degrees
Feed f _z for slot milling in stainless steel > 900 N/mm ²	0.075 mm
Shank	DIN 6535 HB to h6
Corner chamfer width at 45°	0.4 mm
Corner chamfer angle	45 degrees

Data sheet

No. of teeth Z	4
Overhang length L ₁ incl. recess	52 mm
Overall length L	104 mm
Tolerance nominal Ø	e8
Direction of infeed	horizontal, oblique and vertical
Correction factor a _{p corr}	1.5
Shank Ø D _s	20 mm
Recess Ø D ₁	19.5 mm
Coating	AlTiN
Tool material	Solid carbide
Standard	DIN 6527
Milling profile	NF
Cutting width a _e for milling operation	0.3×D for side milling
Cutting width a _e for milling operation	0.5×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 N/mm ²	suitable only under restricted conditions	170 m/min	P
Steel < 750 N/mm ²	suitable only under restricted conditions	150 m/min	P
Steel < 900 N/mm ²	suitable only under restricted conditions	130 m/min	P
Steel < 1100 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		