

**Garant****GARANT INOX solid carbide milling cutter HPC, AlTiN, Ø e8 DC: 1mm****Order data**

Order number	202952 1
GTIN	4069515039505
Item class	11Z

**Description****Version:**

Milling cutter with **optimised geometry** and modern **high-performance coating** for optimum metal removal rate in various **stainless steels**. Can also be used in **duplex materials**.

**Dimensions similar to DIN 6527.**

**Advantage:**

Particularly low vibration running.

**Note:**

**Successor product to 202989.**

**Technical description**

Feed $f_z$ for slot milling in stainless steel $> 900 \text{ N/mm}^2$	0.012 mm
Flute length $L_c$	2.5 mm
Shank	DIN 6535 HA to h6
Shank $\varnothing D_s$	4 mm
Shank form	HA
Cutting edge $\varnothing D_c$	1 mm
Overall length $L$	50 mm
Helix angle	40 degrees
No. of teeth $Z$	4
Tolerance nominal $\varnothing$	e8

## Data sheet

Feed $f_z$ for side milling in INOX > 900 N/mm <sup>2</sup>	0.018 mm
Corner rounding $r_v$	0.05 mm
Direction of infeed	horizontal, oblique and vertical
Recess $\varnothing D_1$	0.9 mm
Overhang length $L_1$ incl. recess	4 mm
Coating	AlTiN
Tool material	Solid carbide
Standard	DIN 6527
Type	N
Spacing of the cutters	unequal spacing
Cutting width $a_e$ for milling operation	0.3×D for side milling
Cutting width $a_e$ for milling operation	0.3×D for side milling
Through-coolant	no
Machining strategy	HPC
Colour ring	blue
Type of product	End / face mill

## User data

	Suitability	$V_c$	ISO code
Steel < 500 N/mm <sup>2</sup>	suitable only under restricted conditions	240 m/min	P
Steel < 750 N/mm <sup>2</sup>	suitable only under restricted conditions	220 m/min	P
Steel < 900 N/mm <sup>2</sup>	suitable only under restricted conditions	200 m/min	P
Steel < 1100 N/mm <sup>2</sup>	suitable only under restricted conditions	180 m/min	P
Steel < 1400 N/mm <sup>2</sup>	suitable only under restricted conditions	150 m/min	P
TOOLOX 33	suitable only under restricted conditions	115 m/min	H

## Data sheet

TOOLOX 44	suitable only under restricted conditions	80 m/min	H
INOX < 900 N/mm <sup>2</sup>	suitable	100 m/min	M
INOX > 900 N/mm <sup>2</sup>	suitable	90 m/min	M
wet maximum	suitable		
wet minimum	suitable		
dry	suitable only under restricted conditions		
Air	suitable		