


**GARANT INOX solid carbide milling cutter HPC, AlTiN, Ø e8 DC: 12mm**

**Order data**

Order number	202952 12
GTIN	4069515039604
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**

Shank	DIN 6535 HB to h6
Recess Ø D <sub>1</sub>	11.6 mm
Shank Ø D <sub>s</sub>	12 mm
Shank form	HB
Direction of infeed	horizontal, oblique and vertical
Feed f <sub>z</sub> for slot milling in stainless steel > 900 N/mm <sup>2</sup>	0.06 mm
Overall length L	83 mm
Tolerance nominal Ø	e8
Cutting edge Ø D <sub>c</sub>	12 mm
Corner rounding r <sub>v</sub>	0.2 mm

## Data sheet

No. of teeth Z	4
Feed $f_z$ for side milling in INOX > 900 N/mm <sup>2</sup>	0.07 mm
Overhang length $L_1$ incl. recess	36 mm
Flute length $L_c$	26 mm
Helix angle	40 degrees
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
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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		