

Garant

GARANT INOX solid carbide milling cutter with chip dividers HPC / TPC, AlTiN, Ø e8 DC: 12mm



Order data

Order number	202956 12
GTIN	4069515039741
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:

With chip divider for controlled chip breaking. For reliable working in automated production environments thanks to reliable chip evacuation from the component. Cutting data for TPC machining in the ToolScout.

Technical description

Shank	DIN 6535 HB to h6
Direction of infeed	horizontal, oblique and vertical
Overhang length L ₁ incl. recess	46 mm
Tolerance nominal Ø	e8
Helix angle	40 degrees
Recess Ø D ₁	11.6 mm
Flute length L _c	39 mm
Number of chip separators	2

Data sheet

Feed f_z for side milling in INOX > 900 N/mm ²	0.062 mm
No. of teeth Z	4
Shank form	HB
Overall length L	93 mm
Cutting edge $\varnothing D_c$	12 mm
Corner rounding r_v	0.2 mm
Shank $\varnothing D_s$	12 mm
Coating	AlTiN
Tool material	Solid carbide
Standard	Manufacturer's standard
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	0.12×D
Through-coolant	no
Machining strategy	HPC
Machining strategy	TPC
Colour ring	blue
Type of product	End / face mill

User data

	Suitability	V_c	ISO code
Steel < 500 N/mm ²	suitable only under restricted conditions	210 m/min	P
Steel < 750 N/mm ²	suitable only under restricted conditions	190 m/min	P
Steel < 900 N/mm ²	suitable only under restricted conditions	170 m/min	P
Steel < 1100 N/mm ²	suitable only under restricted conditions	150 m/min	P

Data sheet

Steel < 1400 N/mm ²	suitable only under restricted conditions	120 m/min	P
TOOLOX 33	suitable only under restricted conditions	110 m/min	H
TOOLOX 44	suitable only under restricted conditions	75 m/min	H
INOX < 900 N/mm ²	suitable	95 m/min	M
INOX > 900 N/mm ²	suitable	85 m/min	M
wet maximum	suitable		
wet minimum	suitable		
dry	suitable only under restricted conditions		
Air	suitable		