

**Garant**

**GARANT INOX solid carbide milling cutter with chip dividers HPC / TPC, AlTiN, Ø e8 DC: 16mm**



## Order data

|              |               |
|--------------|---------------|
| Order number | 202956 16     |
| GTIN         | 4069515039758 |
| 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

|                                                             |          |
|-------------------------------------------------------------|----------|
| Flute length $L_c$                                          | 52 mm    |
| Overall length $L$                                          | 110 mm   |
| Shank form                                                  | HB       |
| Overhang length $L_1$ incl. recess                          | 57 mm    |
| Cutting edge $\varnothing D_c$                              | 16 mm    |
| Feed $f_z$ for side milling in INOX > 900 N/mm <sup>2</sup> | 0.077 mm |
| Recess $\varnothing D_1$                                    | 15.5 mm  |
| Number of chip separators                                   | 2        |

## Data sheet

|                                           |                                  |
|-------------------------------------------|----------------------------------|
| Shank                                     | DIN 6535 HB to h6                |
| Corner rounding $r_v$                     | 0.2 mm                           |
| Direction of infeed                       | horizontal, oblique and vertical |
| No. of teeth Z                            | 4                                |
| Helix angle                               | 40 degrees                       |
| Tolerance nominal $\varnothing$           | e8                               |
| Shank $\varnothing D_s$                   | 16 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 | $0.3 \times D$ for side milling  |
| Cutting width $a_e$ for milling operation | $0.12 \times D$                  |
| 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 <sup>2</sup>  | suitable only under restricted conditions | 210 m/min | P        |
| Steel < 750 N/mm <sup>2</sup>  | suitable only under restricted conditions | 190 m/min | P        |
| Steel < 900 N/mm <sup>2</sup>  | suitable only under restricted conditions | 170 m/min | P        |
| Steel < 1100 N/mm <sup>2</sup> | suitable only under restricted conditions | 150 m/min | P        |

## Data sheet

|                                |                                           |           |   |
|--------------------------------|-------------------------------------------|-----------|---|
| Steel < 1400 N/mm <sup>2</sup> | 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 <sup>2</sup>   | suitable                                  | 95 m/min  | M |
| INOX > 900 N/mm <sup>2</sup>   | suitable                                  | 85 m/min  | M |
| wet maximum                    | suitable                                  |           |   |
| wet minimum                    | suitable                                  |           |   |
| dry                            | suitable only under restricted conditions |           |   |
| Air                            | suitable                                  |           |   |