

Garant
GARANT Master INOX solid carbide milling cutter HPC, TiAlN, Ø h10 DC: 6mm

Order data

Order number	203006 6
GTIN	4045197851789
Item class	11X

Description
Version:

For **roughing and finishing**.

HPC milling cutter with **newly developed high-performance coating** for **outstanding tool life** and **optimum metal removal rate** in a very wide range of stainless steels. **Greater oxidation resistance** and **high-temperature hardness**.

Can be used at **high cutting speeds**, particularly suitable even for TOOLOX®.

Advantage:

Particularly low vibration running.

Technical description

Flute length L_c	13 mm
Recess $\varnothing D_1$	5.5 mm
Tolerance nominal \varnothing	h10
Cutting edge $\varnothing D_c$	6 mm
Overhang length L_1 incl. recess	25 mm
Feed f_z for slot milling in stainless steel $> 900 \text{ N/mm}^2$	0.025 mm
Shank	DIN 6535 HB to h6
Shank $\varnothing D_s$	6 mm
Overall length L	62 mm
Corner chamfer width at 45°	0.25 mm
Feed f_z for side milling in INOX $> 900 \text{ N/mm}^2$	0.03 mm

Direction of infeed	horizontal, oblique and vertical
No. of teeth Z	4
Helix angle	40 degrees
Corner chamfer angle	45 degrees
Series	Master INOX
Coating	TiAlN
Tool material	Solid carbide
Standard	Manufacturer's standard
Type	N
Helix angle characteristic	unequal spacing
Spacing of the cutters	unequal spacing
Cutting width a_e for milling operation	Full slot cutting depth $1 \times D$
Cutting width a_e for milling operation	$0.3 \times D$ 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 ²	suitable	240 m/min	P
Steel < 750 N/mm ²	suitable	220 m/min	P
Steel < 900 N/mm ²	suitable	180 m/min	P
Steel < 1100 N/mm ²	suitable	180 m/min	P
Steel < 1400 N/mm ²	suitable	115 m/min	P
Steel < 50 HRC	suitable	80 m/min	H
INOX < 900 N/mm ²	suitable	100 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