

Garant
GARANT Master INOX solid carbide milling cutter HPC, TiAlN, Ø h10 DC: 12mm

Order data

Order number	203006 12
GTIN	4045197851819
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

Overall length L	93 mm
Corner chamfer width at 45°	0.25 mm
Feed f_z for side milling in INOX > 900 N/mm ²	0.05 mm
Recess Ø D ₁	11.5 mm
Shank	DIN 6535 HB to h6
Shank Ø D _s	12 mm
Tolerance nominal Ø	h10
Cutting edge Ø D _c	12 mm
Overhang length L ₁ incl. recess	48 mm
Direction of infeed	horizontal, oblique and vertical

No. of teeth Z	4
Feed f_z for slot milling in stainless steel $> 900 \text{ N/mm}^2$	0.04 mm
Flute length L_c	26 mm
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 $< 500 \text{ N/mm}^2$	suitable	240 m/min	P
Steel $< 750 \text{ N/mm}^2$	suitable	220 m/min	P
Steel $< 900 \text{ N/mm}^2$	suitable	180 m/min	P
Steel $< 1100 \text{ N/mm}^2$	suitable	180 m/min	P
Steel $< 1400 \text{ N/mm}^2$	suitable	115 m/min	P
Steel $< 50 \text{ HRC}$	suitable	80 m/min	H
INOX $< 900 \text{ N/mm}^2$	suitable	100 m/min	M
INOX $> 900 \text{ N/mm}^2$	suitable	85 m/min	M

wet maximum	suitable
wet minimum	suitable
dry	Suitable only under restricted conditions
Air	suitable