ıỏ Hoffmann Group

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GARANT Master INOX solid carbide milling cutter HPC / TPC, TiAlN, Ø h10 DC: 20mm

Order data

Order number	203011 20
GTIN	4045197851901
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

Overhang length L_1 incl. recess	70 mm
Shank	DIN 6535 HB to h6
Cutting edge Ø D_c	20 mm
Shank Ø D_s	20 mm
Direction of infeed	horizontal, oblique and vertical
Overall length L	126 mm
No. of teeth Z	4
Tolerance nominal Ø	h10
Feed f_z for slot milling in stainless steel > 900 N/mm^2	0.07 mm
Feed f_z for side milling in INOX > 900 N/mm^2	0.08 mm

Recess Ø D_1	19.5 mm
Flute length L_c	60 mm
Corner chamfer width at 45°	0.35 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	0.08×D
Cutting width a_e for milling operation	Full slot cutting depth 1×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/mm²	suitable	240 m/min	P
Steel < 750 N/mm²	suitable	220 m/min	P
Steel < 900 N/mm²	suitable	180 m/min	P
Steel < 1100 N/mm²	suitable	180 m/min	P
Steel < 1400 N/mm²	suitable	115 m/min	P
Steel < 50 HRC	suitable	80 m/min	H
INOX < 900 N/mm²	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		