

Garant
GARANT Master INOX solid carbide milling cutter HPC, TiAlN, Ø h10 DC: 1,5mm

Order data

Order number	202387 1,5
GTIN	4045197875105
Item class	11X

Description
Version:
For roughing and finishing

HPC milling cutters with **newly developed high-performance coating** for **outstanding service life** and **optimum metal removal rates** in a wide range of stainless steels.

Greater oxidation resistance and **high-temperature hardness**.

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

Dimensions similar to **DIN 6527**.

Technical description

Shank Ø D _s	6 mm
Tolerance nominal Ø	h10
Recess Ø D ₁	1.44 mm
No. of teeth Z	3
Cutting edge Ø D _c	1.5 mm
Corner chamfer width at 45°	0.05 mm
Feed f _z for side milling in INOX > 900 N/mm ²	0.012 mm
Overhang length L ₁ incl. recess	7.5 mm
Feed f _z for slot milling in stainless steel > 900 N/mm ²	0.01 mm
Direction of infeed	horizontal, oblique and vertical

Overall length L	57 mm
Flute length L_c	4 mm
Shank	DIN 6535 HB to h6
Helix angle	40 degrees
Corner chamfer angle	45 degrees
Series	Master INOX
Coating	TiAlN
Tool material	Solid carbide
Standard	DIN 6527
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	$0.5 \times D$ 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	250 m/min	P
Steel < 750 N/mm ²	suitable	230 m/min	P
Steel < 900 N/mm ²	suitable	200 m/min	P
Steel < 1100 N/mm ²	suitable	170 m/min	P
Steel < 1400 N/mm ²	suitable only under restricted conditions	170 m/min	P
TOOLOX 33	suitable	115 m/min	H
TOOLOX 44	suitable	80 m/min	H

INOX < 900 N/mm ²	suitable	110 m/min	M
INOX > 900 N/mm ²	suitable	90 m/min	M
Uni	suitable only under restricted conditions		
wet maximum	suitable		
wet minimum	suitable		
dry	suitable only under restricted conditions		
Air	suitable		