Garant

# GARANT Master INOX solid carbide milling cutter HPC, TiAlN, ⌀ h10 DC: 3,5mm

## Order data

| | |
|---|---|
| Order number | 202387 3,5 |
| GTIN | 4045197875143 |
| 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

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|---|---|
| Feed $f_z$ for side milling in INOX > 900 N/mm$^2$ | 0.024 mm |
| Corner chamfer width at 45° | 0.05 mm |
| Feed $f_z$ for slot milling in stainless steel > 900 N/mm$^2$ | 0.02 mm |
| Shank | DIN 6535 HB to h6 |
| Flute length $L_c$ | 11 mm |
| Overhang length $L_1$ incl. recess | 16 mm |
| Overall length L | 57 mm |
| Direction of infeed | horizontal, oblique and vertical |
| Recess ⌀ $D_1$ | 3.4 mm |
| Shank ⌀ $D_s$ | 6 mm |

| | |
|---|---|
| Cutting edge ⌀ $D_C$ | 3.5 mm |
| No. of teeth Z | 3 |
| Tolerance nominal ⌀ | h10 |
| 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×D |
| Cutting width $a_e$ for milling operation | 0.5×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/mm² | suitable | 250 m/min | P |
| Steel < 750 N/mm² | suitable | 230 m/min | P |
| Steel < 900 N/mm² | suitable | 200 m/min | P |
| Steel < 1100 N/mm² | suitable | 170 m/min | P |
| Steel < 1400 N/mm² | 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/mm² | suitable | 110 m/min | M |
| INOX > 900 N/mm² | 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 | | |