

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

**Order data**

Order number	202387 12
GTIN	4045197875259
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 <sub>s</sub>	12 mm
No. of teeth Z	3
Feed f <sub>z</sub> for slot milling in stainless steel > 900 N/mm <sup>2</sup>	0.06 mm
Shank	DIN 6535 HB to h6
Recess Ø D <sub>1</sub>	11.7 mm
Overall length L	83 mm
Flute length L <sub>c</sub>	26 mm
Overhang length L <sub>1</sub> incl. recess	36 mm
Corner chamfer width at 45°	0.1 mm
Tolerance nominal Ø	h10
Cutting edge Ø D <sub>c</sub>	12 mm

Direction of infeed	horizontal, oblique and vertical
Feed $f_z$ for side milling in INOX > 900 N/mm <sup>2</sup>	0.072 mm
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/mm <sup>2</sup>	suitable	250 m/min	P
Steel < 750 N/mm <sup>2</sup>	suitable	230 m/min	P
Steel < 900 N/mm <sup>2</sup>	suitable	200 m/min	P
Steel < 1100 N/mm <sup>2</sup>	suitable	170 m/min	P
Steel < 1400 N/mm <sup>2</sup>	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 <sup>2</sup>	suitable	110 m/min	M

INOX > 900 N/mm <sup>2</sup>	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		