

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**.

Tolerance nominal Ø: h10

No. of teeth Z: 3

Helix angle: 40 °

Direction of infeed: horizontal, oblique and vertical

Shank: DIN 6535 HB to h6

No. of teeth Z: 3

Flute length L_c : 26 mm

Overhang length L_1 incl. recess: 36 mm

Recess Ø D_1 : 11.7 mm

Overall length L: 83 mm

Shank Ø D_s : 12 mm

Technical description

Shank Ø D_s	12 mm
No. of teeth Z	3
Feed f_z for slot milling in stainless steel > 900 N/mm ²	0.06 mm

Shank	DIN 6535 HB to h6
Recess $\varnothing D_1$	11.7 mm
Overall length L	83 mm
Flute length L_c	26 mm
Overhang length L_1 incl. recess	36 mm
Corner chamfer width at 45°	0.1 mm
Tolerance nominal \varnothing	h10
Cutting edge $\varnothing D_c$	12 mm
Direction of infeed	horizontal, oblique and vertical
Feed f_z for side milling in INOX > 900 N/mm ²	0.072 mm
Helix angle	40°
Corner chamfer angle	45°
Series	GARANT 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 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		
Services			

Shank clamping flats for shrink-fit chucks, with retainer function Shank Ø tool 12 mm

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