

Garant

GARANT Master Steel solid carbide finishing cutter HPC, TiAlN, Ø f8 DC: 8mm



Order data

| | |
|--------------|---------------|
| Order number | 204012 8 |
| GTIN | 4045197886606 |
| Item class | 11X |

Description

Version:

For **finishing operations**.

Special geometry for optimum chip evacuation.

Unequal spacing gives high **intrinsic stability and smooth cutting action**.

For **profile milling as a finishing operation**.

Suitable for machining titanium and titanium alloys.

Note:

$$a_{e\max} = 0.1 \times D$$

Can be reground from $\varnothing D_c = 6$ mm.

Technical description

| | |
|--|-------------------|
| Direction of infeed | horizontal |
| Overall length L | 63 mm |
| Flute length L_c | 19 mm |
| Shank $\varnothing D_s$ | 8 mm |
| Corner chamfer width at 45° | 0.08 mm |
| Feed f_z for side milling in steel < 900 N/mm ² | 0.058 mm |
| Cutting edge $\varnothing D_c$ | 8 mm |
| No. of teeth Z | 7 |
| Balance quality with shank | G 2.5 with HA |
| Shank | DIN 6535 HA to h6 |

| | |
|---|---------------------------------|
| Tolerance nominal \varnothing | f8 |
| Helix angle | 45 degrees |
| Corner chamfer angle | 45 degrees |
| Series | Master Steel |
| Coating | TiAlN |
| Tool material | Solid carbide |
| Standard | Manufacturer's standard |
| Type | N |
| Spacing of the cutters | unequal spacing |
| Cutting width a_e for milling operation | $0.1 \times D$ for side milling |
| Through-coolant | no |
| Machining strategy | HPC |
| Colour ring | green |
| Type of product | End / face mill |

User data

| | Suitability | V_c | ISO code |
|--------------------------------|---|-----------|----------|
| Steel < 500 N/mm ² | suitable | 360 m/min | P |
| Steel < 750 N/mm ² | suitable | 340 m/min | P |
| Steel < 900 N/mm ² | suitable | 300 m/min | P |
| Steel < 1100 N/mm ² | suitable | 290 m/min | P |
| Steel < 1400 N/mm ² | suitable | 200 m/min | P |
| INOX < 900 N/mm ² | suitable | 130 m/min | M |
| INOX > 900 N/mm ² | suitable | 120 m/min | M |
| Ti > 850 N/mm ² | suitable only under restricted conditions | 100 m/min | S |
| GG(G) | suitable | 300 m/min | K |
| wet maximum | suitable only under restricted conditions | | |

| | |
|-----------------------------------|---|
| wet minimum | suitable only under restricted conditions |
| dry | suitable only under restricted conditions |
| Air Services | suitable |
| Shank grinding Type HB | 129100 HB |