

Garant
GARANT Master Steel solid carbide finishing cutter HPC, TiAlN, Ø f8 DC: 14mm

Order data

Order number	204016 14
GTIN	4045197886811
Item class	11X

Description
Version:

Suitable for machining titanium and titanium alloys.

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**.

Particularly long cutting edges for efficient finishing.

Note:

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

$a_{e \max} = 0.05 \times D$

Technical description

Feed f_z for side milling in steel $< 900 \text{ N/mm}^2$	0.098 mm
Balance quality with shank	G 2.5 with HA
Cutting edge $\varnothing D_c$	14 mm
Flute length L_c	56 mm
Overall length L	108 mm
Corner chamfer width at 45°	0.14 mm
No. of teeth Z	7
Shank $\varnothing D_s$	14 mm
Tolerance nominal \varnothing	f8

Shank	DIN 6535 HA to h6
Direction of infeed	horizontal
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	$0.05 \times D$ 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	240 m/min	P
Steel < 750 N/mm ²	suitable	220 m/min	P
Steel < 900 N/mm ²	suitable	200 m/min	P
Steel < 1100 N/mm ²	suitable	180 m/min	P
Steel < 1400 N/mm ²	suitable	150 m/min	P
INOX < 900 N/mm ²	suitable	90 m/min	M
INOX > 900 N/mm ²	suitable	80 m/min	M
Ti > 850 N/mm ²	suitable only under restricted conditions	100 m/min	S
GG(G)	suitable	200 m/min	K

wet maximum	suitable only under restricted conditions
wet minimum	suitable only under restricted conditions
dry	suitable only under restricted conditions
Air	suitable