Garant

GARANT Master INOX solid carbide milling cutter HPC, TiAlN, ∅ h10 DC: 3mm

Order data

Order number	202389 3
GTIN	4045197942036
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®.

Technical description

Feed f_z for slot milling in stainless steel > 900 N/mm^2	0.02 mm
Shank	DIN 6535 HB to h6
Cutting edge ∅ D_C	3 mm
Corner chamfer width at 45°	0.05 mm
Overall length L	57 mm
Flute length L_c	8 mm
Recess ∅ D_1	2.9 mm
Tolerance nominal ∅	h10
Feed f_z for side milling in INOX > 900 N/mm^2	0.024 mm
Helix angle	40 degrees
Shank ∅ D_s	6 mm
Overhang length L_1 incl. recess	20 mm

Direction of infeed	horizontal, oblique and vertical
No. of teeth Z	3
Corner chamfer angle	45 degrees
Series	Master INOX
Coating	TiAlN
Tool material	Solid carbide
Standard	Manufacturer's standard
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	0.3×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	240 m/min	P
Steel < 750 N/mm²	suitable	220 m/min	P
Steel < 900 N/mm²	suitable	180 m/min	P
Steel < 1100 N/mm²	suitable	150 m/min	P
Steel < 1400 N/mm²	suitable only under restricted conditions	150 m/min	P
TOOLOX 33	suitable	115 m/min	H
TOOLOX 44	suitable	80 m/min	H
INOX < 900 N/mm²	suitable	100 m/min	M
INOX > 900 N/mm²	suitable	85 m/min	M

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