

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

Order data

Order number	202998 12
GTIN	4045197860972
Item class	11X

Description
Version:

For **roughing and finishing**.

HPC milling cutter with **newly developed high-performance coating** for **outstanding tool life** and **optimum metal removal rate** in a very wide range of stainless steels. **Greater oxidation resistance** and **high-temperature hardness**.

Can be used at **high cutting speeds**, particularly suitable even for TOOLOX®.

Advantage:

Particularly low vibration running.

Technical description

Cutting edge Ø D _c	12 mm
Shank Ø D _s	12 mm
Feed f _z for side milling in INOX > 900 N/mm ²	0.05 mm
Flute length L _c	16 mm
Feed f _z for slot milling in stainless steel > 900 N/mm ²	0.04 mm
Overall length L	73 mm
Corner chamfer width at 45°	0.25 mm
Tolerance nominal Ø	h10
No. of teeth Z	4
Direction of infeed	horizontal, oblique and vertical

Shank	DIN 6535 HB to h6
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 $1 \times D$
Cutting width a_e for milling operation	$0.3 \times D$ 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	180 m/min	P
Steel < 1400 N/mm ²	suitable	115 m/min	P
Steel < 50 HRC	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
wet maximum	suitable		
wet minimum	suitable		

dry	Suitable only under restricted conditions
Air	suitable