

Garant

GARANT Master Steel SlotMachine solid carbide roughing end mill HPC, TiAlN, Ø d11 DC: 14mm



Order data

Order number	205552 14
GTIN	4045197958990
Item class	11X

Description

Version:

With a new-type knurled profile, optimised for higher feed rates. Improved cutting edge protection thanks to slight edge honing. Tremendous bending strength due to the use of ultra-fine grain substrate.

Advantage:

The tool geometry produces particularly tightly rolled swarf that is discharged via flat chip breaker recesses. As a result, the tool maintains an extremely stable core. Plunge angle of up to 10° possible thanks to generous recess on the front face.

Application:

For roughing machining, particularly suitable for full-slot machining.

Technical description

Flute length L_c	26 mm
Tolerance nominal \varnothing	d11
Overhang length L_1 incl. recess	52 mm
No. of teeth Z	5
Corner chamfer width at 45°	0.7 mm
Overall length L	99 mm
Recess $\varnothing D_1$	13 mm
Shank $\varnothing D_s$	14 mm
Shank	DIN 6535 HB to h6

Helix angle	42 degrees
Feed f_z for slot milling in steel < 900 N/mm ²	0.07 mm
Direction of infeed	horizontal, oblique and vertical
Feed f_z for side milling in steel < 900 N/mm ²	0.1 mm
Cutting edge $\varnothing D_c$	14 mm
Corner chamfer angle	45 degrees
Series	Master Steel
Coating	TiAlN
Tool material	Solid carbide
Standard	Manufacturer's standard
Milling profile	NR
Spacing of the cutters	unequal spacing
Cutting width a_e for milling operation	Full slot cutting depth 1xD
Cutting width a_e for milling operation	0.4xD 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	200 m/min	P
Steel < 750 N/mm ²	suitable	180 m/min	P
Steel < 900 N/mm ²	suitable	160 m/min	P
Steel < 1100 N/mm ²	suitable	140 m/min	P
Steel < 1400 N/mm ²	suitable	110 m/min	P
INOX < 900 N/mm ²	suitable	50 m/min	M
INOX > 900 N/mm ²	suitable	35 m/min	M
GG(G)	suitable	200 m/min	K

Uni	suitable
wet maximum	suitable
Air	suitable