

Garant

GARANT Master Steel solid carbide mini milling cutter HPC, TiAlN, Ø e8 DC: 2,5mm



Order data

Order number	202289 2,5
GTIN	4062406271138
Item class	11X

Description

Version:

Extra short cutter for maximum stability. **Shank length to DIN** for improved support of the tool in the holder. This significantly increases the tool life.

Save the regrinding costs: It is cheaper to use a carbide mini slot drill to the limit of wear and throw it away, than to regrind it.

Tool for **general-purpose machining**.

Note:

HB shanks are available at the same price as HA.

For **HB** shanks use order **no. 202291**.

Technical description

Feed f_z for side milling in steel < 900 N/mm ²	0.012 mm
Helix angle	30 degrees
Overall length L	50 mm
Flute length L_c	5 mm
Feed f_z for slot milling in steel < 900 N/mm ²	0.01 mm
Shank $\varnothing D_s$	6 mm
Tolerance nominal \varnothing	e8
Cutting edge $\varnothing D_c$	2.5 mm
No. of teeth Z	3

Shank	DIN 6535 HA to h6
Direction of infeed	horizontal, oblique and vertical
Corner chamfer angle	90 degrees
Series	Master Steel
Coating	TiAlN
Tool material	Solid carbide
Standard	Manufacturer's standard
Type	N
Cutting width a_e for milling operation	Full slot cutting depth $1 \times D$
Cutting width a_e for milling operation	Full slot cutting depth $1 \times D$
Through-coolant	no
Machining strategy	HPC
Colour ring	green
Type of product	End / face mill

User data

	Suitability	V_c	ISO code
Aluminium (short chipping)	suitable only under restricted conditions	290 m/min	N
Alu > 10% Si	suitable only under restricted conditions	240 m/min	N
Steel < 500 N/mm ²	suitable	140 m/min	P
Steel < 750 N/mm ²	suitable	120 m/min	P
Steel < 900 N/mm ²	suitable	100 m/min	P
Steel < 1100 N/mm ²	suitable	70 m/min	P
Steel < 1400 N/mm ²	suitable	50 m/min	P
INOX < 900 N/mm ²	suitable	90 m/min	M
INOX > 900 N/mm ²	suitable	70 m/min	M
Ti > 850 N/mm ²	suitable	40 m/min	S

GG(G)	suitable	85 m/min	K
Uni	suitable		
wet maximum	suitable		
wet minimum	suitable only under restricted conditions		
dry	suitable		
Air	suitable		