

Garant
**GARANT Master INOX solid carbide ball nose milling cutter HPC, TiAlN, Ø f8
DC / DS: 20mm**

Order data

| | |
|--------------|---------------|
| Order number | 207473 20 |
| GTIN | 4062406130381 |
| Item class | 11X |

Description
Version:

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®.

Tolerance: Radius contour = **±0.005 mm**.

Technical description

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|---------------------------------------------------------------------------------|-------------|
| Overall length L | 92 mm |
| No. of teeth Z | 4 |
| Flute length L _c | 26 mm |
| Feed f _z for side milling in INOX < 900 N/mm ² | 0.075 mm |
| Feed f _z for copy milling in stainless steel < 900 N/mm ² | 0.084 mm |
| Helix angle | 45 degrees |
| Cutting edge Ø D _c | 20 mm |
| Shank Ø D _s | 20 mm |
| Radius R | 10 mm |
| Series | Master INOX |

| | |
|-------------------------------------------|--------------------------------------|
| Coating | TiAlN |
| Tool material | Solid carbide |
| Standard | Manufacturer's standard |
| Type | N |
| Tolerance nominal \varnothing | f8 |
| Direction of infeed | horizontal, oblique and vertical |
| Cutting width a_e for milling operation | Full slot cutting depth $1 \times D$ |
| Cutting width a_e for milling operation | $0.05 \times D$ for side milling |
| Shank | DIN 6535 HA to h6 |
| Through-coolant | no |
| Machining strategy | HPC |
| Colour ring | blue |
| Type of product | Ball-nosed slot drill |

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 | 170 m/min | P |
| TOOLOX 33 | suitable | 115 m/min | H |
| TOOLOX 44 | 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 |
| Uni | suitable only under restricted conditions | | |
| wet maximum | suitable | | |
| wet minimum | suitable | | |

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|-----------------------------------|-------------------------------------------|
| dry | suitable only under restricted conditions |
| Air Services | suitable |
| Shank grinding Type HB | 129100 HB |