

Garant

GARANT Master Steel solid carbide finishing cutter HPC, TiAlN, Ø f8 DC: 12mm



Order data

Order number	204019 12
GTIN	4045197954237
Item class	11X

Description

Version:

For **finishing operations**.

Special geometry for optimum chip evacuation.

Unequal spacing gives high **intrinsic stability and smooth cutting action**.

For **profile milling as a finishing operation**.

Particularly long cutting edges for efficient finishing.

Note:

Can be reground from $\varnothing D_c = 6$ mm.

$a_{e\max} = 0.05 \times D$

Technical description

Cutting edge $\varnothing D_c$	12 mm
Helix angle	45 degrees
Shank $\varnothing D_s$	12 mm
Overall length L	112 mm
No. of teeth Z	7
Balance quality with shank	G 2.5 with HA
Flute length L_c	60 mm
Feed f_z for side milling in steel < 900 N/mm ²	0.08 mm
Tolerance nominal \varnothing	f8

Direction of infeed	horizontal
Shank	DIN 6535 HA to h6
Corner chamfer angle	90 degrees
Series	Master Steel
Coating	TiAlN
Tool material	Solid carbide
Standard	Manufacturer's standard
Type	N
Spacing of the cutters	unequal spacing
Cutting width a_e for milling operation	$0.05 \times D$ 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	240 m/min	P
Steel < 750 N/mm ²	suitable	220 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	150 m/min	P
INOX < 900 N/mm ²	suitable	90 m/min	M
INOX > 900 N/mm ²	suitable	80 m/min	M
GG(G)	suitable	200 m/min	K
wet maximum	suitable only under restricted conditions		
wet minimum	suitable only under restricted conditions		

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