

**Garant**
**GARANT Master INOX solid carbide milling cutter HPC / TPC, TiAlN, Ø h10 DC: 2mm**

**Order data**

Order number	203007 2
GTIN	4067263828617
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.

Tolerance nominal Ø: h10

No. of teeth Z: 4

Helix angle: 40 °

Direction of infeed: horizontal, oblique and vertical

Shank: DIN 6535 HB to h6

No. of teeth Z: 4

Flute length  $L_c$ : 5 mm

Overhang length  $L_1$  incl. recess: 13 mm

Recess Ø  $D_1$ : 1.8 mm

Overall length L: 40 mm

Shank Ø  $D_s$ : 4 mm

**Technical description**

Helix angle	40 °
Feed $f_z$ for slot milling in stainless steel > 900 N/mm <sup>2</sup>	0.01 mm
Overall length L	40 mm

Corner chamfer width at 45°	0.15 mm
Recess $\varnothing D_1$	1.8 mm
Tolerance nominal $\varnothing$	h10
Flute length $L_c$	5 mm
Overhang length $L_1$ incl. recess	13 mm
Shank $\varnothing D_s$	4 mm
Cutting edge $\varnothing D_c$	2 mm
Corner chamfer angle	45 °
No. of teeth Z	4
Feed $f_z$ for side milling in INOX > 900 N/mm <sup>2</sup>	0.012 mm
Shank	DIN 6535 HB to h6
Direction of infeed	horizontal, oblique and vertical
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	0.1×D
Cutting width $a_e$ for milling operation	Full slot cutting depth 1×D
Through-coolant	no
Machining strategy	TPC
Machining strategy	HPC
Colour ring	blue
Type of product	End / face mill

## User data

	Suitability	$V_c$	ISO code
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Steel < 500 N/mm <sup>2</sup>	suitable	250 m/min	P
Steel < 750 N/mm <sup>2</sup>	suitable	230 m/min	P
Steel < 900 N/mm <sup>2</sup>	suitable	200 m/min	P
Steel < 1100 N/mm <sup>2</sup>	suitable	180 m/min	P
Steel < 1400 N/mm <sup>2</sup>	suitable	115 m/min	P
Steel < 50 HRC	suitable	80 m/min	H
INOX < 900 N/mm <sup>2</sup>	suitable	110 m/min	M
INOX > 900 N/mm <sup>2</sup>	suitable	90 m/min	M
wet maximum	suitable		
wet minimum	suitable		
dry	Suitable only under restricted conditions		
Air	suitable		