

Garant**GARANT Master Steel solid carbide mini milling cutter HPC, TiAlN, Ø e8 DC: 0,6mm****Order data**

Order number	202289 0,6
GTIN	4062406271039
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

Overall length L	38 mm
Shank Ø D _s	3 mm
Shank	DIN 6535 HA to h6
Helix angle	30 degrees
Feed f _z for side milling in steel < 900 N/mm ²	0.005 mm
No. of teeth Z	3
Direction of infeed	horizontal, oblique and vertical
Cutting edge Ø D _c	0.6 mm
Tolerance nominal Ø	e8

Flute length L_c	1.5 mm
Feed f_z for slot milling in steel $< 900 \text{ N/mm}^2$	0.003 mm
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 $> 10\% \text{ Si}$	suitable only under restricted conditions	240 m/min	N
Steel $< 500 \text{ N/mm}^2$	suitable	140 m/min	P
Steel $< 750 \text{ N/mm}^2$	suitable	120 m/min	P
Steel $< 900 \text{ N/mm}^2$	suitable	100 m/min	P
Steel $< 1100 \text{ N/mm}^2$	suitable	70 m/min	P
Steel $< 1400 \text{ N/mm}^2$	suitable	50 m/min	P
INOX $< 900 \text{ N/mm}^2$	suitable	90 m/min	M
INOX $> 900 \text{ N/mm}^2$	suitable	70 m/min	M
Ti $> 850 \text{ N/mm}^2$	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		