

**Garant**
**GARANT Master INOX solid carbide milling cutter HPC, TiAlN, Ø h10 DC: 1mm**

**Order data**

Order number	202387 1
GTIN	4045197873590
Item class	11X

**Description**
**Version:**

Dimensions similar to **DIN 6527**.

**For roughing and finishing**

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 nominal Ø: h10

No. of teeth Z: 3

Helix angle: 40 °

Direction of infeed: horizontal, oblique and vertical

Shank: DIN 6535 HB to h6

No. of teeth Z: 3

Flute length  $L_c$ : 2.5 mm

Overhang length  $L_1$  incl. recess: 5 mm

Recess Ø  $D_1$ : 0.9 mm

Overall length L: 57 mm

Shank Ø  $D_s$ : 6 mm

**Technical description**

Shank Ø $D_s$	6 mm
Overall length L	57 mm
Flute length $L_c$	2.5 mm
Feed $f_z$ for side milling in INOX > 900 N/mm <sup>2</sup>	0.012 mm

Cutting edge $\varnothing D_c$	1 mm
Direction of infeed	horizontal, oblique and vertical
Shank	DIN 6535 HB to h6
No. of teeth Z	3
Recess $\varnothing D_1$	0.9 mm
Corner chamfer width at 45°	0.05 mm
Tolerance nominal $\varnothing$	h10
Feed $f_z$ for slot milling in stainless steel > 900 N/mm <sup>2</sup>	0.01 mm
Overhang length $L_1$ incl. recess	5 mm
Helix angle	40°
Corner chamfer angle	45°
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	Full slot cutting depth 1×D
Cutting width $a_e$ for milling operation	0.5×D for side milling
Through-coolant	no
Machining strategy	HPC
Colour ring	blue
Type of product	End / face mill

## User data

	Suitability	$V_c$	ISO code
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	170 m/min	P
Steel < 1400 N/mm <sup>2</sup>	suitable only under restricted conditions	170 m/min	P
TOOLOX 33	suitable	115 m/min	H
TOOLOX 44	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
Uni	suitable only under restricted conditions		
wet maximum	suitable		
wet minimum	suitable		
dry	suitable only under restricted conditions		
Air	suitable		