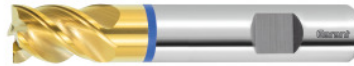


**Garant**
**GARANT Master INOX M solid carbide milling cutter HPC, TiAlN, Ø e8 DC: 6mm**

**Order data**

Order number	202986 6
GTIN	4062406242305
Item class	11X

**Description**
**Version:**

Milling cutter with newly **developed high-performance coating** for **outstanding tool working life** and **optimum metal removal rates** in a wide range of stainless steels. Can be used at high **cutting speeds**, e.g. in duplex steels.

**Note:**

**Successor product to No. 202993.**

Tolerance nominal Ø: e8

No. of teeth Z: 4

Helix angle: 42 °

Direction of infeed: horizontal, oblique and vertical

Shank: DIN 6535 HB to h6

No. of teeth Z: 4

Flute length  $L_c$ : 10 mm

Overhang length  $L_1$  incl. recess: 16 mm

Recess Ø  $D_1$ : 5.8 mm

Overall length L: 54 mm

Shank Ø  $D_s$ : 6 mm

**Technical description**

Shank	DIN 6535 HB to h6
Overhang length $L_1$ incl. recess	16 mm
Recess Ø $D_1$	5.8 mm

Helix angle	42 °
Direction of infeed	horizontal, oblique and vertical
No. of teeth Z	4
Flute length $L_c$	10 mm
Overall length L	54 mm
Shank $\varnothing D_s$	6 mm
Cutting edge $\varnothing D_c$	6 mm
Feed $f_z$ for side milling in INOX > 900 N/mm <sup>2</sup>	0.05 mm
Tolerance nominal $\varnothing$	e8
Feed $f_z$ for slot milling in stainless steel > 900 N/mm <sup>2</sup>	0.04 mm
Corner rounding $r_v$	0.1 mm
Series	Master Inox
Coating	TiAlN
Tool material	solid carbide
Standard	Manufacturer's standard
Type	N
Helix angle characteristic	unequal spacing
Spacing of the cutters	unequal spacing
Cutting width $a_e$ for milling operation	Full slot cutting depth 1xD
Cutting width $a_e$ for milling operation	Full slot cutting depth 1xD
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	180 m/min	P
Steel < 1400 N/mm <sup>2</sup>	suitable	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	100 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		