

**Garant**
**GARANT Master Steel solid carbide finishing cutter HPC, TiAlN, Ø f8 DC: 8mm**

**Order data**

Order number	204019 8
GTIN	4045197954213
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.

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

Tolerance nominal  $\varnothing$ : f8

No. of teeth Z: 7

Helix angle: 45 °

Direction of infeed: horizontal

Shank: DIN 6535 HA to h6

Balance quality with shank: G 2.5 with HA

No. of teeth Z: 7

Flute length  $L_c$ : 40 mm

Overall length L: 81 mm

Shank  $\varnothing D_s$ : 8 mm

Feed  $f_z$  for side milling in steel  $< 900$  N/mm<sup>2</sup>: 0.043 mm

**Technical description**

Direction of infeed	horizontal
Balance quality with shank	G 2.5 with HA
Feed $f_z$ for side milling in steel $< 900$ N/mm <sup>2</sup>	0.043 mm

Shank	DIN 6535 HA to h6
Overall length L	81 mm
Helix angle	45 °
Shank $\varnothing D_s$	8 mm
Cutting edge $\varnothing D_c$	8 mm
No. of teeth Z	7
Flute length $L_c$	40 mm
Tolerance nominal $\varnothing$	f8
Corner chamfer angle	90 °
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×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 <sup>2</sup>	suitable	240 m/min	P
Steel < 750 N/mm <sup>2</sup>	suitable	220 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	150 m/min	P
INOX < 900 N/mm <sup>2</sup>	suitable	90 m/min	M

INOX > 900 N/mm <sup>2</sup>	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		
<del>Air</del> <b>Services</b>	suitable		
Shank grinding Type HB	129100 HB		