

Garant

GARANT Master INOX M SlotMachine solid carbide roughing end mill HPC, TiAlN, Ø d11 DC: 8mm



Order data

Order number	205450 8
GTIN	4062406276089
Item class	11X

Description

Version:

With a **new type of knuckle form profile**, optimised for higher feed rates. Improved cutting edge protection thanks to slight edge honing. **Tremendous bending strength** due to the use of **ultra-fine grain substrate**. Number of cutters selected for performance and process reliability.

Advantage:

The tool geometry produces particularly tightly rolled swarf that is discharged via flat chip breaker recesses. As a result, the tool maintains an **extremely stable core**.

Application:

For roughing machining, particularly suitable for full-slot machining.

Recommendation:

To ensure reliable working, particularly for full slot milling, use arbors with **4 cooling channel bores**.

Tolerance nominal Ø: d11

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 : 19 mm

Overhang length L_1 incl. recess: 25 mm

Recess Ø D_1 : 7.4 mm

Overall length L: 63 mm

Shank Ø D_s : 8 mm

Technical description

Flute length L_c	19 mm
Helix angle	40°
Corner chamfer width at 45°	0.2 mm
Feed f_z for side milling in INOX > 900 N/mm ²	0.035 mm
Feed f_z for slot milling in stainless steel > 900 N/mm ²	0.03 mm
Cutting edge $\varnothing D_c$	8 mm
Shank	DIN 6535 HB to h6
Recess $\varnothing D_1$	7.4 mm
Overall length L	63 mm
Overhang length L_1 incl. recess	25 mm
Tolerance nominal \varnothing	d11
Direction of infeed	horizontal, oblique and vertical
No. of teeth Z	4
Corner chamfer angle	45°
Shank $\varnothing D_s$	8 mm
Series	Master Inox
Coating	TiAlN
Tool material	Solid carbide
Standard	DIN 6527
Milling profile	NR
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
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Steel < 500 N/mm ²	suitable only under restricted conditions	150 m/min	P
Steel < 750 N/mm ²	suitable	140 m/min	P
Steel < 900 N/mm ²	suitable	120 m/min	P
Steel < 1100 N/mm ²	suitable	110 m/min	P
Steel < 1400 N/mm ²	suitable	100 m/min	P
INOX < 900 N/mm ²	suitable	90 m/min	M
INOX > 900 N/mm ²	suitable	80 m/min	M
Uni	suitable		
wet maximum	suitable		
wet minimum	suitable only under restricted conditions		
Air	suitable		