

Garant

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



Order data

Order number	205454 8
GTIN	4062406380687
Item class	11X

Description

Version:

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

Problem-solver for **TPC machining**. Ideal for automated production as the risk of chip accumulations in the machine is largely prevented.

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**.

Recommendation:

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

Note:

h_{max} : The values stated in the table are maximum values.

$ae_{max} = 0.05 \times D$ for TPC machining.

Machining strategy: HPC

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 : 33 mm

Overhang length L_1 incl. recess: 40 mm

Recess Ø D_1 : 7.4 mm

Overall length L: 79 mm
Shank $\varnothing D_s$: 8 mm

Technical description

Corner chamfer angle	45 °
Tolerance nominal \varnothing	d11
Overall length L	79 mm
Corner chamfer width at 45°	0.2 mm
Overhang length L_1 incl. recess	40 mm
Shank	DIN 6535 HB to h6
Direction of infeed	horizontal, oblique and vertical
Helix angle	40 °
Average chip thickness h_{max} for TPC milling in INOX < 900 N/mm ²	0.038 mm
No. of teeth Z	4
Shank $\varnothing D_s$	8 mm
Recess $\varnothing D_1$	7.4 mm
Cutting edge $\varnothing D_c$	8 mm
Flute length L_c	33 mm
Series	Master Inox
Coating	TiAlN
Tool material	Solid carbide
Standard	Manufacturer's standard
Milling profile	NF
Cutting width a_e for milling operation	0.05×D
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 ²	suitable only under restricted conditions	130 m/min	P
Steel < 750 N/mm ²	suitable	120 m/min	P
Steel < 900 N/mm ²	suitable	100 m/min	P
Steel < 1100 N/mm ²	suitable only under restricted conditions	95 m/min	P
Steel < 1400 N/mm ²	suitable only under restricted conditions	85 m/min	P
INOX < 900 N/mm ²	suitable	75 m/min	M
INOX > 900 N/mm ²	suitable	70 m/min	M
Uni	suitable only under restricted conditions		
wet maximum	suitable		
wet minimum	suitable only under restricted conditions		
Air	Suitable only under restricted conditions		