

## Garant

### GARANT Master Steel SlotMachine solid carbide roughing end mill HPC / TPC, TiAlN, Ø d11 DC: 8mm



#### Order data

Order number	205554 8
GTIN	4045197959942
Item class	11X

#### Description

##### Version:

With a new-type knurled 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.

##### 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.

Plunge angle of up to 10° possible thanks to generous recess on the front face.

##### Application:

For roughing machining.

##### Problem-solver for TPC machining.

Tolerance nominal Ø: d11

No. of teeth Z: 5

Helix angle: 42°

Direction of infeed: horizontal, oblique and vertical

Shank: DIN 6535 HB to h6

No. of teeth Z: 5

Flute length  $L_c$ : 24 mm

Overhang length  $L_1$  incl. recess: 30 mm

Recess Ø  $D_1$ : 7.4 mm

Overall length L: 68 mm

Shank Ø  $D_s$ : 8 mm

#### Technical description

No. of teeth Z	5
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Feed $f_z$ for side milling in steel < 900 N/mm <sup>2</sup>	0.06 mm
Cutting edge $\varnothing D_c$	8 mm
Helix angle	42 °
Flute length $L_c$	24 mm
Shank $\varnothing D_s$	8 mm
Shank	DIN 6535 HB to h6
Feed $f_z$ for slot milling in steel < 900 N/mm <sup>2</sup>	0.04 mm
Tolerance nominal $\varnothing$	d11
Overhang length $L_1$ incl. recess	30 mm
Recess $\varnothing D_1$	7.4 mm
Corner chamfer width at 45°	0.4 mm
Overall length $L$	68 mm
Direction of infeed	horizontal, oblique and vertical
Corner chamfer angle	45 °
Series	Master Steel
Coating	TiAlN
Tool material	Solid carbide
Standard	Manufacturer's standard
Milling profile	NR
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	0.4×D for side milling
Through-coolant	no
Machining strategy	HPC
Machining strategy	TPC
Colour ring	green
Type of product	End / face mill

## User data

	<b>Suitability</b>	<b>V<sub>c</sub></b>	<b>ISO code</b>
Steel < 500 N/mm <sup>2</sup>	suitable	200 m/min	P
Steel < 750 N/mm <sup>2</sup>	suitable	180 m/min	P
Steel < 900 N/mm <sup>2</sup>	suitable	160 m/min	P
Steel < 1100 N/mm <sup>2</sup>	suitable	140 m/min	P
Steel < 1400 N/mm <sup>2</sup>	suitable	110 m/min	P
INOX < 900 N/mm <sup>2</sup>	suitable	50 m/min	M
INOX > 900 N/mm <sup>2</sup>	suitable	35 m/min	M
GG(G)	suitable	200 m/min	K
Uni	suitable		
wet maximum	suitable		
wet minimum	suitable only under restricted conditions		
dry	suitable		
Air	suitable		