

**Garant**
**Solid carbide milling cutter HPC, TiAlN, Ø DC: 12M mm**

**Order data**

Order number	203009 12M
GTIN	4045197657220
Item class	11X

**Description**
**Version:**

Specially for **machining stainless steels such as duplex steels at high rates of metal removal.**

Cutting edge chamfer: Size 4 = 0.07mm; size 5 – 8 = 0.12 mm; size 10 – 18 = 0.2 mm; ≥ size 20 = 0.3 mm

Tolerance nominal Ø: h10

No. of teeth Z: 4

Helix angle: 38 degrees

Direction of infeed: horizontal, oblique and vertical

Shank: DIN 6535 HB to h6

No. of teeth Z: 4

Flute length  $L_c$ : 36 mm

Overhang length  $L_1$  incl. recess: 45 mm

Recess Ø  $D_1$ : 11.6 mm

Overall length L: 93 mm

Shank Ø  $D_s$ : 12 mm

**Technical description**

Feed $f_z$ for slot milling in stainless steel > 900 N/mm <sup>2</sup>	0.04 mm
No. of teeth Z	4
Overhang length $L_1$ incl. recess	45 mm
Cutting edge Ø $D_c$	12 mm
Feed $f_z$ for side milling in INOX > 900 N/mm <sup>2</sup>	0.065 mm
Corner chamfer width at 45°	0.2 mm

Recess $\varnothing D_1$	11.6 mm
Shank $\varnothing D_s$	12 mm
Overall length L	93 mm
Flute length $L_c$	36 mm
Direction of infeed	horizontal, oblique and vertical
Shank	DIN 6535 HB to h6
Tolerance nominal $\varnothing$	h10
Helix angle	38 degrees
Corner chamfer angle	45 degrees
Coating	TiAlN
Tool material	Solid carbide
Standard	DIN 6527
Type	N
Helix angle characteristic	unequal spacing
Spacing of the cutters	unequal spacing
Cutting width $a_e$ for milling operation	0.3×D for side milling
Cutting width $a_e$ for milling operation	Full slot cutting depth 1×D
Through-coolant	no
Machining strategy	HPC
Colour ring	blue
Type of product	End mill

## Services

Shank recess Type FRST	209900 FRST
Shank clamping flats for shrink-fit chucks, with retainer function Shank $\varnothing$ tool 12 mm	SZ2025 12