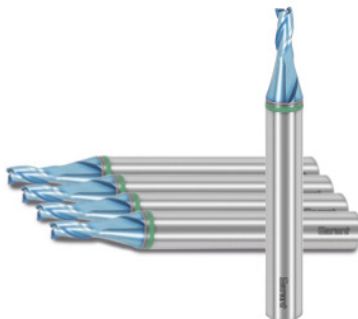


Garant**Value pack GARANT Master Steel solid carbide mini milling cutter HPC, 5 pieces****Order data**

Order number	GG2289 5,5
GTIN	4067263091219
Item class	GGN

Description**Version:**

Extra short cutter for maximum stability. **Shank length to DIN** for improved support of the tool in the holder. This significantly increases the tool life.

Save the regrinding costs: It is cheaper to use a carbide mini milling cutter to the limit of wear and throw it away, than to regrind it.

Same as No. 202289.

Technical description

Flute length L_c	8 mm
Tolerance nominal $\varnothing$	e8
Contents	5
Shank	DIN 6535 HA to h6
Corner chamfer angle	90 degrees
Shank $\varnothing D_s$	6 mm

Feed f_z for side milling in steel $< 900 \text{ N/mm}^2$	0.028 mm
Shank form	HA
No. of teeth Z	3
Overall length L	50 mm
Direction of infeed	horizontal, oblique and vertical
Feed f_z for slot milling in steel $< 900 \text{ N/mm}^2$	0.025 mm
Helix angle	30 degrees
Cutting edge $\varnothing D_c$	5.5 mm
Series	Master Steel
Coating	TiAlN
Tool material	Solid carbide
Standard	Works standard
Type	N
Cutting width a_e for milling operation	$0.3 \times D$ for side milling
Cutting width a_e for milling operation	$0.5 \times D$ 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
Aluminium (short chipping)	suitable only under restricted conditions	290 m/min	N
Alu $> 10\% \text{ Si}$	suitable only under restricted conditions	240 m/min	N
Steel $< 500 \text{ N/mm}^2$	suitable	140 m/min	P
Steel $< 750 \text{ N/mm}^2$	suitable	120 m/min	P
Steel $< 900 \text{ N/mm}^2$	suitable	100 m/min	P

Steel < 1100 N/mm ²	suitable	70 m/min	P
Steel < 1400 N/mm ²	suitable	50 m/min	P
INOX < 900 N/mm ²	suitable	90 m/min	M
INOX > 900 N/mm ²	suitable	70 m/min	M
Ti > 850 N/mm ²	suitable only under restricted conditions	40 m/min	S
GG(G)	suitable	85 m/min	K
Uni	suitable		
wet maximum	suitable		
wet minimum	suitable only under restricted conditions		
dry	suitable		
Air	suitable		

Accessories

GARANT Master Steel solid carbide mini milling cutterHPC
Ø e8 DC 5,5 mm

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