

Garant
Solid carbide milling cutter with chip separators TPC, TiAlN, Ø f8 DC: 4mm

Order data

Order number	203089 4
GTIN	4045197778871
Item class	11X

Description

Version:

High-performance milling cutter specially designed for general-purpose TPC applications. Strengthened core. Optimised bending strength due to the use of ultra-fine grain substrates.

Note:

$a_e \max = 0.07 \times D$ for TPC machining. h_{\max} : The values stated in the table are maximum values. For finishing operations we recommend items No. 204012, 204014 and 204015. NEW GENERATION AVAILABLE! Recommended successor product is No. 203092.

Technical description

Overall length L	62 mm
Overhang length L_1 incl. recess	23 mm
No. of teeth Z	5
Flute length L_c	16 mm
Shank	DIN 6535 HB to h6
Shank $\varnothing D_s$	6 mm
Tolerance nominal \varnothing	f8
Corner chamfer width at 45°	0.08 mm
Direction of infeed	horizontal and oblique
Recess $\varnothing D_1$	3.9 mm

Average chip thickness h_{\max} for TPC milling in Toolox 44 HRC	0.018 mm
Balance quality with shank	G 2.5 with HB
Cutting edge $\varnothing D_c$	4 mm
Helix angle	40 degrees
Corner chamfer angle	45 degrees
Number of chip separators	1
Coating	TiAlN
Tool material	Solid carbide
Standard	Manufacturer's standard
Type	N
Helix angle characteristic	unequal spacing
Spacing of the cutters	unequal spacing
Cutting width a_e for milling operation	$0.07 \times D$
Through-coolant	no
Machining strategy	TPC
Colour ring	green
Type of product	End / face mill

User data

	Suitability	V_c	ISO code
Steel < 500 N/mm ²	suitable	380 m/min	P
Steel < 750 N/mm ²	suitable	340 m/min	P
Steel < 900 N/mm ²	suitable	300 m/min	P
Steel < 1100 N/mm ²	suitable	230 m/min	P
Steel < 1400 N/mm ²	suitable	150 m/min	P
TOOLOX 33	suitable	60 m/min	H
TOOLOX 44	suitable	40 m/min	H

HARDOX 500 < 1600 N/mm ²	suitable	25 m/min	H
INOX < 900 N/mm ²	suitable	220 m/min	M
INOX > 900 N/mm ²	suitable only under restricted conditions	150 m/min	M
Uni	suitable		
wet maximum	Suitable		
dry	Suitable only under restricted conditions		
Air	suitable		