Garant

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

Order data

Order number	203019 4
GTIN	4045197778895
Item class	11X

Description

Version:
High-performance mills for machining stainless steels, **specially designed for TPC applications**. Strengthened core.
Note:
h_{max}: The values stated in the table are maximum values.
$a_{e\,max}$ = 0.08×D for TPC machining.
NEW GENERATION AVAILABLE!
Recommended successor product is No. 203103

Technical description

Shank ⌀ D_s	6 mm
Cutting edge ⌀ D_C	4 mm
Average chip thickness h_{max} for TPC milling in INOX < 900 N/mm²	0.025 mm
Corner chamfer width at 45°	0.08 mm
No. of teeth Z	5
Shank	DIN 6535 HB to h6
Recess ⌀ D_1	3.9 mm
Balance quality with shank	G 2.5 with HB
Overhang length L_1 incl. recess	23 mm
Tolerance nominal ⌀	f8

Direction of infeed	horizontal and oblique
Overall length L	62 mm
Average chip thickness h_{max} for TPC milling in INOX > 900 N/mm²	0.02 mm
Flute length L_c	16 mm
Helix angle	45 degrees
Corner chamfer angle	45 degrees
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	0.08×D
Through-coolant	no
Machining strategy	TPC
Colour ring	blue
Type of product	End / face mill

User data

	Suitability	V_c	ISO code
Steel < 500 N/mm²	suitable	380 m/min	P
Steel < 750 N/mm²	suitable	340 m/min	P
Steel < 900 N/mm²	suitable	300 m/min	P
Steel < 1100 N/mm²	suitable	230 m/min	P
INOX < 900 N/mm²	suitable	240 m/min	M
INOX > 900 N/mm²	suitable	170 m/min	M
wet maximum	Suitable		

wet minimum	Suitable only under restricted conditions
Air	suitable