

Garant
GARANT Master INOX solid carbide milling cutter HPC / TPC, TiAlN, Ø h10 DC: 4mm

Order data

Order number	202999 4
GTIN	4062406233648
Item class	11X

Description
Version:

For **roughing and finishing**.

HPC milling cutter with **newly developed high-performance coating** for **outstanding tool life** and **optimum metal removal rate** in a very wide range of stainless steels. **Greater oxidation resistance** and **high-temperature hardness**.

Can be used at **high cutting speeds**, particularly suitable even for TOOLOX®.

With **internal coolant supply** for reliable chip evacuation.

Advantage:

Particularly low vibration running.

Technical description

Recess Ø D ₁	3.8 mm
Tolerance nominal Ø	h10
Shank	DIN 6535 HB to h6
Overhang length L ₁ incl. recess	21 mm
Corner chamfer width at 45°	0.15 mm
Helix angle	40 degrees
Feed f _z for side milling in INOX > 900 N/mm ²	0.015 mm
Cutting edge Ø D _c	4 mm
No. of teeth Z	4

Direction of infeed	horizontal, oblique and vertical
Overall length L	57 mm
Feed f_z for slot milling in stainless steel $> 900 \text{ N/mm}^2$	0.012 mm
Flute length L_c	11 mm
Shank $\varnothing D_s$	6 mm
Corner chamfer angle	45 degrees
Series	Master INOX
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	Full slot cutting depth $1 \times D$
Cutting width a_e for milling operation	$0.1 \times D$
Through-coolant	yes
Machining strategy	TPC
Machining strategy	HPC
Colour ring	blue
Type of product	End / face mill

User data

	Suitability	V_c	ISO code
Steel $< 500 \text{ N/mm}^2$	suitable	250 m/min	P
Steel $< 750 \text{ N/mm}^2$	suitable	230 m/min	P
Steel $< 900 \text{ N/mm}^2$	suitable	200 m/min	P
Steel $< 1100 \text{ N/mm}^2$	suitable	180 m/min	P
Steel $< 1400 \text{ N/mm}^2$	suitable	115 m/min	P
Steel $< 50 \text{ HRC}$	suitable	80 m/min	H

INOX < 900 N/mm ²	suitable	110 m/min	M
INOX > 900 N/mm ²	suitable	90 m/min	M
wet maximum	suitable		
Air	suitable		