

Garant
GARANT Master Alu solid carbide milling cutter HPC, DLC, Ø DC: 4mm

Order data

Order number	202512 4
GTIN	4062406238827
Item class	11X

Description
Version:
Extra sharp cutting edges.

Dimensions similar to DIN6527.

For roughing and finishing. Up to 2xD into solid material at very high feed rates and smooth cutting action.

With the latest generation of **DLC coating sp²**.

Note:

Successor product to No. 202515.

Technical description

Shank	DIN 6535 HA to h6
Recess Ø D ₁	3.7 mm
Cutting edge Ø D _c	4 mm
Direction of infeed	horizontal, oblique and vertical
Overhang length L ₁ incl. recess	18 mm
Tolerance nominal Ø	h6
Shank Ø D _s	6 mm
Feed f _z for side milling in short-chipping aluminium	0.06 mm
Helix angle	38 degrees
Flute length L _c	13 mm

No. of teeth Z	4
Overall length L	57 mm
Feed f_z for slot milling in short-chipping aluminium	0.05 mm
Corner chamfer angle	90 degrees
Series	Master Alu
Coating	DLC
Tool material	Solid carbide
Standard	DIN 6527
Type	W
Cutting width a_e for milling operation	Full slot cutting depth $1 \times D$
Cutting width a_e for milling operation	$0.25 \times D$ for side milling
Through-coolant	no
Machining strategy	HPC
Colour ring	yellow
Type of product	End / face mill

User data

	Suitability	V_c	ISO code
Aluminium	suitable	550 m/min	N
Aluminium (short chipping)	suitable	500 m/min	N
Alu > 10% Si	suitable	450 m/min	N
PMMA acrylic	Suitable	200 m/min	N
PE-HD	Suitable	160 m/min	N
PA 66	Suitable	200 m/min	N
PEEK	Suitable	150 m/min	N
PF 31	Suitable	130 m/min	N
PVDF GF20	suitable	180 m/min	N
POM GF25	Suitable	160 m/min	N

PA 66 GF30	suitable	150 m/min	N
PEEK GF30	suitable	130 m/min	N
PTFE CF25	suitable	160 m/min	N
Honeycomb sandwich	suitable	300 m/min	N
Cu	Suitable	160 m/min	N
CuZn	Suitable	200 m/min	N
wet maximum	suitable		
wet minimum	suitable only under restricted conditions		
dry	suitable only under restricted conditions		
Air	suitable		

Services

Shank grinding Type HB

129100 HB