

Garant

GARANT Master INOX M SlotMachine solid carbide roughing end mill HPC, TiAlN, Ø d11 DC: 4mm



Order data

Order number	205450 4
GTIN	4062406276058
Item class	11X

Description

Version:

With a **new type of knuckle form profile**, optimised for higher feed rates. Improved cutting edge protection thanks to slight edge honing. **Tremendous bending strength** due to the use of **ultra-fine grain substrate**. Number of cutters selected for performance and process reliability.

Advantage:

The tool geometry produces particularly tightly rolled swarf that is discharged via flat chip breaker recesses. As a result, the tool maintains an **extremely stable core**.

Application:

For roughing machining, particularly suitable for full-slot machining.

Recommendation:

To ensure reliable working, particularly for full slot milling, use arbors with **4 cooling channel bores**.

Technical description

Feed f_z for side milling in INOX > 900 N/mm ²	0.015 mm
Shank	DIN 6535 HB to h6
Cutting edge $\varnothing D_c$	4 mm
Flute length L_c	11 mm
Shank $\varnothing D_s$	6 mm
Tolerance nominal \varnothing	d11
Direction of infeed	horizontal, oblique and vertical

Overall length L	57 mm
Feed f_z for slot milling in stainless steel $> 900 \text{ N/mm}^2$	0.01 mm
Helix angle	40 degrees
Recess $\varnothing D_1$	3.7 mm
Overhang length L_1 incl. recess	19 mm
Corner chamfer width at 45°	0.15 mm
No. of teeth Z	4
Corner chamfer angle	45 degrees
Series	Master INOX
Coating	TiAlN
Tool material	Solid carbide
Standard	DIN 6527
Milling profile	NR
Cutting width a_e for milling operation	Full slot cutting depth $1 \times D$
Cutting width a_e for milling operation	Full slot cutting depth $1 \times D$
Through-coolant	no
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 only under restricted conditions	150 m/min	P
Steel $< 750 \text{ N/mm}^2$	suitable	140 m/min	P
Steel $< 900 \text{ N/mm}^2$	suitable	120 m/min	P
Steel $< 1100 \text{ N/mm}^2$	suitable	110 m/min	P
Steel $< 1400 \text{ N/mm}^2$	suitable	100 m/min	P
INOX $< 900 \text{ N/mm}^2$	suitable	90 m/min	M

INOX > 900 N/mm ²	suitable	80 m/min	M
Uni	suitable		
wet maximum	suitable		
wet minimum	suitable only under restricted conditions		
Air	suitable		