

Garant
Solid carbide chamfer mill, spiral flutes 90°, TiAlN, Ø e8 DC: 4mm

Order data

Order number	208088 4
GTIN	4062406390563
Item class	11X

Description
Version:

Outstanding surface qualities thanks to the **35° helix angle**. Chamfer mill for **universal application** in virtually all materials. The newly developed coating effectively prevents built-up edges, even in aluminium or stainless steel.

Tolerance: Point angle ± 5 arc minutes.

Application:

- **Centring**
- **Drilling**
- **Countersinking**
- **Chamfering**

Technical description

No. of teeth Z	2
Feed f_z for side milling in steel < 900 N/mm ²	0.03 mm
Flute length L_c	11 mm
Shank	DIN 6535 HA to h6
Overall length L	57 mm
Corner chamfer angle	45 degrees
Shank $\varnothing D_s$	6 mm
Chamfer mill	45 degrees
Feed f_z for side milling in INOX > 900 N/mm ²	0.027 mm

Cutting edge $\varnothing D_c$	4 mm
Coating	TiAlN
Tool material	Solid carbide
Standard	Manufacturer's standard
Type	N
Tolerance nominal \varnothing	e8
Helix angle	35 degrees
Cutting width a_e for milling operation	0.5×D for side milling
Countersink tip angle	90 degrees
Through-coolant	no
Shank tolerance	h6
Colour ring	without
Type of product	Indexable end mill

User data

	Suitability	V_c	ISO code
Alu plastics	suitable only under restricted conditions	180 m/min	N
Aluminium (short chipping)	suitable	300 m/min	N
Alu > 10% Si	suitable	220 m/min	N
Steel < 500 N/mm ²	suitable	130 m/min	P
Steel < 750 N/mm ²	suitable	115 m/min	P
Steel < 900 N/mm ²	suitable	110 m/min	P
Steel < 1100 N/mm ²	suitable	80 m/min	P
Steel < 1400 N/mm ²	suitable only under restricted conditions	65 m/min	P
Steel < 55 HRC	suitable only under restricted conditions	35 m/min	H
INOX < 900 N/mm ²	suitable	90 m/min	M

INOX > 900 N/mm ²	suitable	70 m/min	M
Ti > 850 N/mm ²	suitable	50 m/min	S
GG(G)	suitable	100 m/min	K
Uni	suitable		
wet maximum	suitable		
wet minimum	suitable only under restricted conditions		
dry	suitable only under restricted conditions		
Air	suitable only under restricted conditions		

Services

Shank grinding Type HB

129100 HB