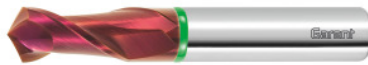


**Garant**
**Solid carbide chamfer mill, spiral flutes 120°, TiAlN, Ø e8 DC: 4mm**


## Order data

Order number	208089 4
GTIN	4062406390655
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

Feed $f_z$ for side milling in steel < 900 N/mm <sup>2</sup>	0.03 mm
Overall length L	57 mm
No. of teeth Z	2
Shank	DIN 6535 HA to h6
Flute length $L_c$	11 mm
Corner chamfer angle	60 degrees
Cutting edge Ø $D_c$	4 mm
Shank Ø $D_s$	6 mm
Chamfer mill	60 degrees

Feed $f_z$ for side milling in INOX > 900 N/mm <sup>2</sup>	0.027 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	120 degrees
Through-coolant	no
Shank tolerance	h6
Colour ring	green
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 <sup>2</sup>	suitable	130 m/min	P
Steel < 750 N/mm <sup>2</sup>	suitable	115 m/min	P
Steel < 900 N/mm <sup>2</sup>	suitable	110 m/min	P
Steel < 1100 N/mm <sup>2</sup>	suitable	80 m/min	P
Steel < 1400 N/mm <sup>2</sup>	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 <sup>2</sup>	suitable	90 m/min	M

INOX > 900 N/mm <sup>2</sup>	suitable	70 m/min	M
Ti > 850 N/mm <sup>2</sup>	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