

**Garant**
**Solid carbide side milling cutter HPC, TiAlN,  $\varnothing \times \text{width} \pm 0.1 \times k11$ : 40X4mm**

**Order data**

Order number	185015 40X4
GTIN	4062406397326
Item class	11V

**Description**
**Version:**

**Precision solid carbide side milling cutters** in the HPC machining range. **With new high-performance coating** for very long tool life.

**Use as a set:** Cutters with the same  $\varnothing$  and same number of teeth can be combined as a set and adjusted to the required width. Since the cutters have no raised bore collar, the staggered teeth mesh with each other.

**2-piece sets are particularly economical.** By reversing the side milling cutters, both side edges of each cutter can be used.

**Note:**

- **Do not clamp the cutters in a set without a sufficiently thick arbor spacer ring, otherwise the cutters will be damaged.**
- **See Product Group 30 for suitable arbor spacer rings.**
- **Slots milled from solid:  $f_z$  for  $a_e = 0.1 \times D$ .**

**Successor product to No. 185010.**

**Technical description**

Collar thickness $b \pm 0.1$	2.8 mm
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Tooth height Zh	6 mm
Capability of combining 2 cutters of the same width A/B	4 mm
Shank type	with bore
Collar $\varnothing d_2 \pm 1$	28 mm
Cutting edge $\varnothing D_c$	40 mm
Capability of combining 2 cutters of the same width, results in overall width E	7.7 - 7.8 mm
Bore $\varnothing H6 d_1$	13 mm
Feed $f_z$ in steel $< 900 \text{ N/mm}^2$	0.03 mm
Cutting width	4 mm
No. of teeth Z	12
Coating	TiAlN
Tool material	Solid carbide
Standard	DIN 885 A
Type	N
Tolerance nominal $\varnothing$	$\pm 0.1$
Cutting width $a_e$ for milling operation	Full slot cutting depth $1 \times D$
Machining strategy	HPC
Through-coolant	no
Colour ring	without
Type of product	Side milling cutter

## User data

	Suitability	$V_c$	ISO code
Alu plastics	suitable	280 m/min	N
Aluminium (short chipping)	suitable	280 m/min	N
Alu $> 10\% \text{ Si}$	suitable	200 m/min	N
Steel $< 500 \text{ N/mm}^2$	suitable	120 m/min	P

Steel < 750 N/mm <sup>2</sup>	suitable	110 m/min	P
Steel < 900 N/mm <sup>2</sup>	suitable	100 m/min	P
Steel < 1100 N/mm <sup>2</sup>	suitable	90 m/min	P
Steel < 1400 N/mm <sup>2</sup>	suitable	75 m/min	P
INOX < 900 N/mm <sup>2</sup>	suitable	45 m/min	M
GG(G)	suitable	70 m/min	K
CuZn	suitable	300 m/min	N
Oil	suitable only under restricted conditions		
wet maximum	suitable		