

Garant**Solid carbide side milling cutter HPC, TiAlN, $\varnothing \times \text{width} \pm 0.1 \times k11$: 100X4mm****Order data**

Order number	185015 100X4
GTIN	4062406397562
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 $b \pm 0.1$	2.3 mm
------------------------------	--------

Shank type	with bore
Cutting width	4 mm
Feed f_z in steel $< 900 \text{ N/mm}^2$	0.045 mm
Bore $\varnothing \text{ H6 d}_1$	27 mm
Capability of combining 2 cutters of different width, results in overall width E	8.1 - 8.8 mm
Capability of combining 2 cutters of the same width, results in overall width E	7.3 - 7.8 mm
Cutting edge $\varnothing D_c$	100 mm
Capability of combining 2 cutters of different width B	5 mm
Capability of combining 2 cutters of different width A	4 mm
No. of teeth Z	22
Collar $\varnothing d_2 \pm 1$	60 mm
Tooth height Zh	20 mm
Capability of combining 2 cutters of the same width A/B	4 mm
Coating	TiAlN
Tool material	Solid carbide
Standard	DIN 885 A
Type	N
Tolerance nominal \varnothing	± 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% Si	suitable	200 m/min	N
Steel < 500 N/mm ²	suitable	120 m/min	P
Steel < 750 N/mm ²	suitable	110 m/min	P
Steel < 900 N/mm ²	suitable	100 m/min	P
Steel < 1100 N/mm ²	suitable	90 m/min	P
Steel < 1400 N/mm ²	suitable	75 m/min	P
INOX < 900 N/mm ²	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		