

**Garant**
**Solid carbide milling cutter HPC, TiAlN, Ø DC: 4mm**

**Order data**

Order number	203009 4
GTIN	4045197588609
Item class	11X

**Description**
**Version:**

Specially for **machining stainless steels such as duplex steels at high rates of metal removal.**  
 Cutting edge chamfer: Size 4 = 0.07mm; size 5 – 8 = 0.12 mm; size 10 – 18 = 0.2 mm; ≥ size 20 = 0.3 mm

**Technical description**

Overhang length $L_1$ incl. recess	18 mm
Feed $f_z$ for slot milling in stainless steel $> 900 \text{ N/mm}^2$	0.012 mm
Recess $\varnothing D_1$	3.8 mm
Cutting edge $\varnothing D_c$	4 mm
Feed $f_z$ for side milling in INOX $> 900 \text{ N/mm}^2$	0.02 mm
Corner chamfer width at $45^\circ$	0.07 mm
No. of teeth $Z$	4
Shank $\varnothing D_s$	6 mm
Overall length $L$	57 mm
Flute length $L_c$	11 mm
Direction of infeed	horizontal, oblique and vertical
Shank	DIN 6535 HB to h6
Tolerance nominal $\varnothing$	h10

Helix angle	38 degrees
Corner chamfer angle	45 degrees
Coating	TiAlN
Tool material	Solid carbide
Standard	DIN 6527
Type	N
Helix angle characteristic	unequal spacing
Spacing of the cutters	unequal spacing
Cutting width $a_e$ for milling operation	0.3×D for side milling
Cutting width $a_e$ for milling operation	Full slot cutting depth 1×D
Through-coolant	no
Machining strategy	HPC
Colour ring	blue
Type of product	End / face mill

### User data

	Suitability	$V_c$	ISO code
INOX < 900 N/mm <sup>2</sup>	suitable	110 m/min	M
INOX > 900 N/mm <sup>2</sup>	suitable	90 m/min	M
wet maximum	suitable		
wet minimum	suitable		
dry	Suitable only under restricted conditions		
Air	suitable		