

Garant
Solid carbide roughing end mill HPC, AlCrN, Ø e8 DC: 4mm

Order data

| | |
|--------------|---------------|
| Order number | 203072 4 |
| GTIN | 4062406565145 |
| Item class | 11X |

Description
Version:

For **roughing and finishing**. Up to 1.5xD into solid material **at very high feed rates** with smooth cutting action. Optimised end face geometry.

Application:

- **Optimised flute form, eccentric relief ground.**
- **Large flute profiles.**
- **Improved chip evacuation due to optimised end face geometry.**
- **Minimal wear due to sturdy cutting edges.**

Technical description

| | |
|---|----------------------------------|
| No. of teeth Z | 4 |
| Cutting edge Ø D _c | 4 mm |
| Corner chamfer width at 45° | 0.1 mm |
| Overall length L | 57 mm |
| Shank Ø D _s | 6 mm |
| Direction of infeed | horizontal, oblique and vertical |
| Flute length L _c | 11 mm |
| Feed f _z for slot milling in steel < 900 N/mm ² | 0.028 mm |
| Corner chamfer angle | 45 degrees |
| Shank | DIN 6535 HB to h6 |

| | |
|--|-----------------------------|
| Feed f_z for side milling in steel < 900 N/mm ² | 0.055 mm |
| Tolerance nominal \varnothing | e8 |
| Helix angle | 38 degrees |
| Coating | AlCrN |
| 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 | MTC |
| Colour ring | green |
| Type of product | End / face mill |

User data

| | Suitability | V_c | ISO code |
|--------------------------------|---|-----------|----------|
| Steel < 500 N/mm ² | suitable | 265 m/min | P |
| Steel < 750 N/mm ² | suitable | 250 m/min | P |
| Steel < 900 N/mm ² | suitable | 200 m/min | P |
| Steel < 1100 N/mm ² | suitable | 180 m/min | P |
| Steel < 1400 N/mm ² | suitable only under restricted conditions | 160 m/min | P |
| INOX < 900 N/mm ² | suitable only under restricted conditions | 100 m/min | M |
| INOX > 900 N/mm ² | suitable only under restricted conditions | 90 m/min | M |
| GG(G) | suitable | 250 m/min | K |
| Uni | suitable | | |

| | |
|-------------|---|
| wet maximum | suitable |
| wet minimum | suitable only under restricted conditions |
| dry | suitable |
| Air | suitable |