

Garant
GARANT Master UNI solid carbide milling cutter HPC, TiSiN, Ø e8 DC: 4mm

Order data

Order number	203062 4
GTIN	4062406569532
Item class	11Z

Description
Version:

For **roughing and finishing at very high feed rates** with smooth cutting action. **Newly developed geometry and high-performance coating** for outstanding production results and very long tool life with a variety of materials. Unequal spacing gives **high intrinsic stability** and smooth cutting action.

Advantage:

- **Particularly low vibration running.**
- **Special flute profile, large flutes.**
- **Specially matched edge honing.**
- **Optimised substrate for hardness and toughness.**

Technical description

Flute length L_c	8 mm
Shank	DIN 6535 HB to h6
No. of teeth Z	4
Feed f_z for side milling in INOX > 900 N/mm ²	0.015 mm
Overall length L	54 mm
Feed f_z for slot milling in stainless steel > 900 N/mm ²	0.012 mm
Tolerance nominal Ø	e8
Recess Ø D_1	3.8 mm
Cutting edge Ø D_c	4 mm

Helix angle	42 degrees
Overhang length L_1 incl. recess	14 mm
Corner rounding r_v	0.1 mm
Shank $\varnothing D_s$	6 mm
Feed f_z for slot milling in steel $< 900 \text{ N/mm}^2$	0.02 mm
Direction of infeed	horizontal, oblique and vertical
Feed f_z for side milling in steel $< 900 \text{ N/mm}^2$	0.025 mm
Series	Master Uni
Coating	TiSiN
Tool material	solid carbide
Standard	Manufacturer's standard
Type	N
Helix angle characteristic	unequal spacing
Spacing of the cutters	unequal spacing
Cutting width a_e for milling operation	Full slot cutting depth $1 \times D$
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Through-coolant	no
Machining strategy	HPC
Colour ring	green
Type of product	End / face mill

User data

	Suitability	V_c	ISO code
Aluminium (short chipping)	suitable only under restricted conditions	280 m/min	N
Steel $< 500 \text{ N/mm}^2$	suitable	260 m/min	P
Steel $< 750 \text{ N/mm}^2$	suitable	240 m/min	P
Steel $< 900 \text{ N/mm}^2$	suitable	190 m/min	P
Steel $< 1100 \text{ N/mm}^2$	suitable	180 m/min	P

Steel < 1400 N/mm ²	suitable	150 m/min	P
INOX < 900 N/mm ²	suitable	90 m/min	M
INOX > 900 N/mm ²	suitable	80 m/min	M
Ti > 850 N/mm ²	suitable only under restricted conditions	40 m/min	S
GG(G)	suitable	250 m/min	K
Uni	suitable		
wet maximum	suitable		
wet minimum	suitable only under restricted conditions		
dry	suitable		
Air	suitable		