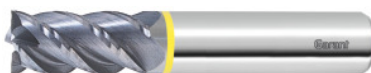


Garant
Solid carbide milling cutter DIN 6535 HA, uncoated, Ø DC: 4mm

Order data

Order number	202480 4
GTIN	4045197117090
Item class	11X

Description
Version:
Extra sharp cutting edges.

Dimensions similar to DIN 6527.

Double relief ground side clearance angle.

Technical description

Recess Ø D ₁	3.8 mm
Feed f _z for slot milling in short-chipping aluminium	0.015 mm
Overhang length L ₁ incl. recess	18 mm
No. of teeth Z	4
Cutting edge Ø D _c	4 mm
Feed f _z for side milling in short-chipping aluminium	0.02 mm
Shank Ø D _s	6 mm
Overall length L	57 mm
Flute length L _c	13 mm
Direction of infeed	horizontal, oblique and vertical
Shank	DIN 6535 HA to h6
Tolerance nominal Ø	h6
Helix angle	38 degrees

Corner chamfer angle	90 degrees
Coating	uncoated
Tool material	Solid carbide
Standard	DIN 6527
Type	W
Cutting width a_e for milling operation	0.5×D for side milling
Cutting width a_e for milling operation	Full slot cutting depth 1×D
Through-coolant	no
Colour ring	yellow
Type of product	End / face mill

User data

	Suitability	V_c	ISO code
Aluminium	Suitable	180 m/min	N
Aluminium (short chipping)	suitable	140 m/min	N
Alu > 10% Si	suitable	105 m/min	N
PMMA acrylic	Suitable	180 m/min	N
PE-HD	Suitable	130 m/min	N
PA 66	Suitable	150 m/min	N
PEEK	Suitable	130 m/min	N
PF 31	Suitable	110 m/min	N
Honeycomb sandwich	suitable only under restricted conditions	180 m/min	N
Cu	Suitable	140 m/min	N
CuZn	Suitable	180 m/min	N
wet maximum	suitable		
wet minimum	suitable only under restricted conditions		

dry	suitable only under restricted conditions
Air	suitable only under restricted conditions
Services	
Shank grinding Type HB	129100 HB