

**Garant**
**Solid carbide milling cutter, TiAlN, Ø e8 DC: 4mm**

**Order data**

Order number	202556 4
GTIN	4067263080305
Item class	11X

**Description**
**Version:**

Double relief ground side clearance angle.

**Note:**

**Successor product to No. 202555.**

**Technical description**

No. of teeth Z	4
Feed $f_z$ for side milling in steel < 900 N/mm <sup>2</sup>	0.023 mm
Direction of infeed	horizontal, oblique and vertical
Overall length L	36 mm
Feed $f_z$ for slot milling in steel < 900 N/mm <sup>2</sup>	0.02 mm
Corner chamfer angle	45 degrees
Helix angle	30 degrees
Cutting edge Ø $D_c$	4 mm
Tolerance nominal Ø	e8
Flute length $L_c$	8 mm
Corner chamfer width at 45°	0.05 mm
Shank	DIN 6535 HA to h6
Shank form	HA

Shank $\varnothing D_s$	4 mm
Coating	TiAlN
Tool material	Solid carbide
Standard	Manufacturer's standard
Type	N
Cutting width $a_e$ for milling operation	0.3xD for side milling
Cutting width $a_e$ for milling operation	0.3xD for side milling
Through-coolant	no
Colour ring	without
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
Alu > 10% Si	suitable only under restricted conditions	200 m/min	N
Steel < 500 N/mm <sup>2</sup>	suitable	120 m/min	P
Steel < 750 N/mm <sup>2</sup>	suitable	105 m/min	P
Steel < 900 N/mm <sup>2</sup>	suitable	100 m/min	P
Steel < 1100 N/mm <sup>2</sup>	suitable	70 m/min	P
Steel < 1400 N/mm <sup>2</sup>	suitable	60 m/min	P
Steel < 55 HRC	suitable	35 m/min	H
INOX < 900 N/mm <sup>2</sup>	suitable	80 m/min	M
INOX > 900 N/mm <sup>2</sup>	suitable only under restricted conditions	60 m/min	M
GG(G)	suitable	90 m/min	K
Uni	suitable		
wet maximum	suitable		

wet minimum	suitable only under restricted conditions
dry	suitable
Air	suitable