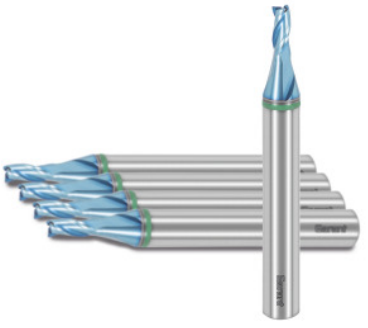
Garant

GARANT Master Steel solid carbide mini milling cutter HPC, TiAlN, ∅ e8 DC: 4mm



Order data

Order number	GG2289 4
GTIN	4067263091080
Item class	GGN

Description

Version:
Extra short cutter for maximum stability. **Shank length to DIN** for improved support of the tool in the holder. This significantly increases the tool life.
Save the regrinding costs: It is cheaper to use a carbide mini slot drill to the limit of wear and throw it away, than to regrind it.
Same as No. 202289.

Technical description

Contents	5
Direction of infeed	horizontal, oblique and vertical
Cutting edge ∅ D_C	4 mm
Feed f_z for slot milling in steel < 900 N/mm^2	0.02 mm
Flute length L_c	7 mm
Tolerance nominal ∅	e8

Helix angle	30 degrees
Shank	DIN 6535 HA to h6
Corner chamfer angle	90 degrees
Overall length L	50 mm
Shank ⌀ D_s	6 mm
No. of teeth Z	3
Feed f_z for side milling in steel < 900 N/mm^2	0.022 mm
Shank form	HA
Series	Master Steel
Coating	TiAlN
Tool material	Solid carbide
Standard	Works standard
Type	N
Cutting width a_e for milling operation	0.3×D for side milling
Cutting width a_e for milling operation	0.5×D for side milling
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	290 m/min	N
Alu > 10% Si	suitable only under restricted conditions	240 m/min	N
Steel < 500 N/mm^2	suitable	140 m/min	P
Steel < 750 N/mm^2	suitable	120 m/min	P
Steel < 900 N/mm^2	suitable	100 m/min	P

Steel < 1100 N/mm²	suitable	70 m/min	P
Steel < 1400 N/mm²	suitable	50 m/min	P
INOX < 900 N/mm²	suitable	90 m/min	M
INOX > 900 N/mm²	suitable	70 m/min	M
Ti > 850 N/mm²	suitable only under restricted conditions	40 m/min	S
GG(G)	suitable	85 m/min	K
Uni	suitable		
wet maximum	suitable		
wet minimum	suitable only under restricted conditions		
dry	suitable		
Air	suitable		

Accessories

GARANT Master Steel solid carbide mini milling cutterHPC ∅ e8 DC 4 mm	202289 4