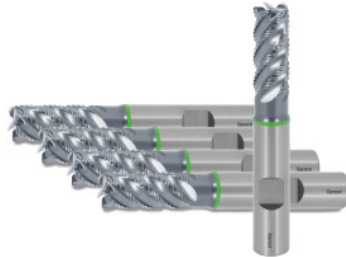


**Garant****GARANT Master Steel SlotMachine solid carbide roughing end mill HPC, TiAlN, Ø d11 DC: 4mm****Order data**

Order number	GG1050 4
GTIN	4067263134886
Item class	GGN

**Description****Version:**

With a new-type knurled profile, optimised for higher feed rates. Improved cutting edge protection thanks to slight edge honing. Tremendous bending strength due to the use of ultra-fine grain substrate.

Feed rate per tooth up to 0.1 mm up to a depth of 2×D (in the slot milled from solid).

**Same as 205550.**

**Advantage:**

The tool geometry produces particularly tightly rolled swarf that is discharged via flat chip breaker recesses. As a result, the tool maintains an extremely stable core. Plunge angle of up to 10° possible thanks to generous recess on the front face.

**Application:**

For roughing machining, particularly suitable for full-slot machining.

**Technical description**

Helix angle	42 degrees
Corner chamfer width at 45°	0.2 mm
Tolerance nominal Ø	d11

Feed $f_z$ for slot milling in steel $< 900 \text{ N/mm}^2$	0.02 mm
Recess $\varnothing D_1$	3.7 mm
Direction of infeed	horizontal, oblique and vertical
Corner chamfer angle	45 degrees
Shank $\varnothing D_s$	6 mm
Overhang length $L_1$ incl. recess	19 mm
Flute length $L_c$	11 mm
Shank	DIN 6535 HB to h6
Overall length $L$	57 mm
No. of teeth $Z$	5
Feed $f_z$ for side milling in steel $< 900 \text{ N/mm}^2$	0.03 mm
Cutting edge $\varnothing D_c$	4 mm
Series	Master Steel
Coating	TiAlN
Tool material	Solid carbide
Standard	DIN 6527
Milling profile	NR
Spacing of the cutters	unequal spacing
Cutting width $a_e$ for milling operation	$0.3 \times D$ for side milling
Cutting width $a_e$ for milling operation	$0.3 \times D$ 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
Steel $< 500 \text{ N/mm}^2$	suitable	200 m/min	P
Steel $< 750 \text{ N/mm}^2$	suitable	180 m/min	P

Steel < 900 N/mm <sup>2</sup>	suitable	160 m/min	P
Steel < 1100 N/mm <sup>2</sup>	suitable	140 m/min	P
Steel < 1400 N/mm <sup>2</sup>	suitable	110 m/min	P
INOX < 900 N/mm <sup>2</sup>	suitable	50 m/min	M
INOX > 900 N/mm <sup>2</sup>	suitable	35 m/min	M
GG(G)	suitable	200 m/min	K
Uni	suitable		
wet maximum	suitable		
wet minimum	suitable only under restricted conditions		
dry	suitable		
Air	suitable		

## Accessories

GARANT Master Steel SlotMachine solid carbide roughing end millHPC Ø d11 DC 4 mm

205550 4