

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

Order number	GG1048 4
GTIN	4067263134770
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 205548.

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

Flute length L_c	8 mm
No. of teeth Z	5
Corner chamfer angle	45 degrees

Feed f_z for slot milling in steel < 900 N/mm ²	0.03 mm
Overall length L	54 mm
Shank	DIN 6535 HB to h6
Feed f_z for side milling in steel < 900 N/mm ²	0.04 mm
Corner chamfer width at 45°	0.2 mm
Cutting edge Ø D _c	4 mm
Shank Ø D _s	6 mm
Tolerance nominal Ø	d11
Helix angle	42 degrees
Direction of infeed	horizontal, oblique and vertical
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×D for side milling
Cutting width a _e for milling operation	0.3×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 N/mm ²	suitable	200 m/min	P
Steel < 750 N/mm ²	suitable	180 m/min	P
Steel < 900 N/mm ²	suitable	160 m/min	P
Steel < 1100 N/mm ²	suitable	140 m/min	P

Steel < 1400 N/mm ²	suitable	110 m/min	P
INOX < 900 N/mm ²	suitable	50 m/min	M
INOX > 900 N/mm ²	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

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