


GARANT INOX solid carbide milling cutter HPC, AlTiN, Ø e8 DC: 4mm

Order data

Order number	202950 4
GTIN	4069515039406
Item class	11Z

Description
Version:

Milling cutter with **optimised geometry** and modern **high-performance coating** for optimum metal removal rate in various **stainless steels**. Can also be used in **duplex materials**.

Dimensions similar to DIN 6527.

Note:

Successor product to 202986.

Technical description

Cutting edge Ø D _c	4 mm
Shank	DIN 6535 HB to h6
Recess Ø D ₁	3.8 mm
Corner rounding r _v	0.1 mm
Direction of infeed	horizontal, oblique and vertical
Tolerance nominal Ø	e8
No. of teeth Z	4
Feed f _z for side milling in INOX > 900 N/mm ²	0.035 mm
Overall length L	54 mm
Flute length L _c	8 mm
Shank Ø D _s	6 mm

Data sheet

Shank form	HA
Helix angle	40 degrees
Feed f_z for slot milling in stainless steel $> 900 \text{ N/mm}^2$	0.025 mm
Coating	AlTiN
Tool material	Solid carbide
Standard	DIN 6527
Type	N
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	blue
Type of product	End / face mill

User data

	Suitability	V_c	ISO code
Steel $< 500 \text{ N/mm}^2$	suitable only under restricted conditions	240 m/min	P
Steel $< 750 \text{ N/mm}^2$	suitable only under restricted conditions	220 m/min	P
Steel $< 900 \text{ N/mm}^2$	suitable only under restricted conditions	200 m/min	P
Steel $< 1100 \text{ N/mm}^2$	suitable only under restricted conditions	180 m/min	P
Steel $< 1400 \text{ N/mm}^2$	suitable only under restricted conditions	150 m/min	P
TOOLOX 33	suitable only under restricted conditions	115 m/min	H
TOOLOX 44	suitable only under restricted conditions	80 m/min	H

Data sheet

INOX < 900 N/mm ²	suitable	100 m/min	M
INOX > 900 N/mm ²	suitable	90 m/min	M
wet maximum	suitable		
wet minimum	suitable		
dry	suitable only under restricted conditions		
Air	suitable		