

Garant

GARANT INOX solid carbide milling cutter with chip dividers HPC / TPC, AlTiN, Ø e8 DC: 4mm



Order data

Order number	202954 4
GTIN	4069515039635
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.

Advantage:

Particularly low vibration running.

Note:

With chip dividers for controlled chip breaking. For reliable working in automated production environments thanks to reliable chip evacuation from the component. Cutting data for TPC machining in the ToolScout.

Technical description

Tolerance nominal Ø	e8
Shank	DIN 6535 HB to h6
Recess Ø D ₁	3.8 mm
No. of teeth Z	4
Shank Ø D _s	6 mm
Helix angle	40 degrees
Feed f _z for side milling in INOX > 900 N/mm ²	0.012 mm
Corner rounding r _v	0.1 mm

Data sheet

Shank form	HB
Flute length L_c	11 mm
Number of chip separators	1
Cutting edge $\varnothing D_c$	4 mm
Overall length L	57 mm
Direction of infeed	horizontal, oblique and vertical
Overhang length L_1 incl. recess	17 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	$0.15 \times D$
Through-coolant	no
Machining strategy	HPC
Machining strategy	TPC
Colour ring	blue
Type of product	End / face mill

User data

	Suitability	V_c	ISO code
Steel < 500 N/mm ²	suitable only under restricted conditions	240 m/min	P
Steel < 750 N/mm ²	suitable only under restricted conditions	220 m/min	P
Steel < 900 N/mm ²	suitable only under restricted conditions	200 m/min	P
Steel < 1100 N/mm ²	suitable only under restricted conditions	180 m/min	P

Data sheet

Steel < 1400 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
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		