

**Garant**
**GARANT Master INOX solid carbide milling cutter HPC, TiAlN, Ø h10 DC: 4mm**

**Order data**

Order number	202387 4
GTIN	4045197875150
Item class	11X

**Description**
**Version:**
**For roughing and finishing**

HPC milling cutters with **newly developed high-performance coating** for **outstanding service life** and **optimum metal removal rates** in a wide range of stainless steels.

**Greater oxidation resistance** and **high-temperature hardness**.

Can be used at **high cutting speeds**, particularly suitable even for TOOLOX®.

Dimensions similar to **DIN 6527**.

**Technical description**

No. of teeth Z	3
Shank	DIN 6535 HB to h6
Flute length $L_c$	11 mm
Overall length L	57 mm
Shank $\varnothing D_s$	6 mm
Cutting edge $\varnothing D_c$	4 mm
Recess $\varnothing D_1$	3.9 mm
Tolerance nominal $\varnothing$	h10
Feed $f_z$ for side milling in INOX > 900 N/mm <sup>2</sup>	0.024 mm
Corner chamfer width at 45°	0.1 mm
Overhang length $L_1$ incl. recess	16 mm

Direction of infeed	horizontal, oblique and vertical
Feed $f_z$ for slot milling in stainless steel $> 900 \text{ N/mm}^2$	0.02 mm
Helix angle	40 degrees
Corner chamfer angle	45 degrees
Series	Master INOX
Coating	TiAlN
Tool material	Solid carbide
Standard	DIN 6527
Type	N
Helix angle characteristic	unequal spacing
Spacing of the cutters	unequal spacing
Cutting width $a_e$ for milling operation	Full slot cutting depth $1 \times D$
Cutting width $a_e$ for milling operation	$0.5 \times D$ 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	250 m/min	P
Steel $< 750 \text{ N/mm}^2$	suitable	230 m/min	P
Steel $< 900 \text{ N/mm}^2$	suitable	200 m/min	P
Steel $< 1100 \text{ N/mm}^2$	suitable	170 m/min	P
Steel $< 1400 \text{ N/mm}^2$	suitable only under restricted conditions	170 m/min	P
TOOLOX 33	suitable	115 m/min	H
TOOLOX 44	suitable	80 m/min	H
INOX $< 900 \text{ N/mm}^2$	suitable	110 m/min	M

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