

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

**Order data**

Order number	202389 4
GTIN	4045197875297
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®.

**Technical description**

Cutting edge Ø D <sub>c</sub>	4 mm
Recess Ø D <sub>1</sub>	3.9 mm
Feed f <sub>z</sub> for side milling in INOX > 900 N/mm <sup>2</sup>	0.024 mm
Direction of infeed	horizontal, oblique and vertical
Overhang length L <sub>1</sub> incl. recess	24 mm
Tolerance nominal Ø	h10
Overall length L	62 mm
Shank	DIN 6535 HB to h6
Corner chamfer width at 45°	0.1 mm
No. of teeth Z	3
Feed f <sub>z</sub> for slot milling in stainless steel > 900 N/mm <sup>2</sup>	0.02 mm
Flute length L <sub>c</sub>	16 mm

Shank $\varnothing D_s$	6 mm
Helix angle	40 degrees
Corner chamfer angle	45 degrees
Series	Master INOX
Coating	TiAlN
Tool material	Solid carbide
Standard	Manufacturer's standard
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	$0.3 \times D$ 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 N/mm <sup>2</sup>	suitable	240 m/min	P
Steel < 750 N/mm <sup>2</sup>	suitable	220 m/min	P
Steel < 900 N/mm <sup>2</sup>	suitable	180 m/min	P
Steel < 1100 N/mm <sup>2</sup>	suitable	150 m/min	P
Steel < 1400 N/mm <sup>2</sup>	suitable only under restricted conditions	150 m/min	P
TOOLOX 33	suitable	115 m/min	H
TOOLOX 44	suitable	80 m/min	H
INOX < 900 N/mm <sup>2</sup>	suitable	100 m/min	M
INOX > 900 N/mm <sup>2</sup>	suitable	85 m/min	M

Uni	suitable only under restricted conditions
wet maximum	suitable
wet minimum	suitable
dry	suitable only under restricted conditions
Air	suitable