

Garant
GARANT Master Steel solid carbide finishing cutter HPC, TiAlN, Ø f8 DC: 4mm

Order data

Order number	204012 4
GTIN	4045197886378
Item class	11X

Description
Version:

For **finishing operations**.

Special geometry for optimum chip evacuation.

Unequal spacing gives high **intrinsic stability and smooth cutting action**.

For **profile milling as a finishing operation**.

Suitable for machining titanium and titanium alloys.

Note:

$$a_{e\max} = 0.1 \times D$$

Can be reground from $\varnothing D_c = 6$ mm.

Technical description

Shank $\varnothing D_s$	6 mm
Overall length L	57 mm
Cutting edge $\varnothing D_c$	4 mm
Flute length L_c	11 mm
Balance quality with shank	G 2.5 with HA
Corner chamfer width at 45°	0.04 mm
Feed f_z for side milling in steel < 900 N/mm ²	0.02 mm
No. of teeth Z	7
Shank	DIN 6535 HA to h6
Tolerance nominal \varnothing	f8

Direction of infeed	horizontal
Helix angle	45 degrees
Corner chamfer angle	45 degrees
Series	Master Steel
Coating	TiAlN
Tool material	Solid carbide
Standard	Manufacturer's standard
Type	N
Spacing of the cutters	unequal spacing
Cutting width a_e for milling operation	$0.1 \times D$ 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	360 m/min	P
Steel < 750 N/mm ²	suitable	340 m/min	P
Steel < 900 N/mm ²	suitable	300 m/min	P
Steel < 1100 N/mm ²	suitable	290 m/min	P
Steel < 1400 N/mm ²	suitable	200 m/min	P
INOX < 900 N/mm ²	suitable	130 m/min	M
INOX > 900 N/mm ²	suitable	120 m/min	M
Ti > 850 N/mm ²	suitable only under restricted conditions	100 m/min	S
GG(G)	suitable	300 m/min	K
wet maximum	suitable only under restricted conditions		

wet minimum	suitable only under restricted conditions
dry	suitable only under restricted conditions
Air Services	suitable
Shank grinding Type HB	129100 HB