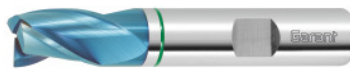


Garant
GARANT Master Steel solid carbide mini-milling cutter HPC, TiAlN, Ø e8 DC: 4mm

Order data

Order number	202291 4
GTIN	4062406271565
Item class	11X

Description
Version:

Extra short cutter for maximum stability. **Shank length to DIN** for improved support of the tool in the holder. This significantly increases the tool life.

Save the regrinding costs: It is cheaper to use a carbide mini slot drill to the limit of wear and throw it away, than to regrind it.

Tool for **general-purpose machining**.

Tolerance nominal Ø: e8

No. of teeth Z: 3

Helix angle: 30 °

Direction of infeed: horizontal, oblique and vertical

Shank: DIN 6535 HB to h6

No. of teeth Z: 3

Flute length L_c : 7 mm

Overall length L: 50 mm

Shank Ø D_s : 6 mm

Feed f_z for slot milling in steel < 900 N/mm²: 0.02 mm

Feed f_z for side milling in steel < 900 N/mm²: 0.022 mm

Technical description

Feed f_z for slot milling in steel < 900 N/mm ²	0.02 mm
Shank	DIN 6535 HB to h6
Tolerance nominal Ø	e8

No. of teeth Z	3
Shank $\varnothing D_s$	6 mm
Direction of infeed	horizontal, oblique and vertical
Cutting edge $\varnothing D_c$	4 mm
Overall length L	50 mm
Feed f_z for side milling in steel $< 900 \text{ N/mm}^2$	0.022 mm
Flute length L_c	7 mm
Helix angle	30°
Corner chamfer angle	90°
Series	Master Steel
Coating	TiAlN
Tool material	Solid carbide
Standard	Manufacturer's standard
Type	N
Helix angle characteristic	1
Cutting width a_e for milling operation	Full slot cutting depth 1xD
Cutting width a_e for milling operation	Full slot cutting depth 1xD
Through-coolant	no
Machining strategy	HPC
Colour ring	green
Type of product	End / face mill

User data

	Suitability	V_c	ISO code
Aluminium (short chipping)	suitable only under restricted conditions	290 m/min	N
Alu $> 10\% \text{ Si}$	suitable only under restricted conditions	240 m/min	N
Steel $< 500 \text{ N/mm}^2$	suitable	140 m/min	P

Steel < 750 N/mm ²	suitable	120 m/min	P
Steel < 900 N/mm ²	suitable	100 m/min	P
Steel < 1100 N/mm ²	suitable	70 m/min	P
Steel < 1400 N/mm ²	suitable	50 m/min	P
INOX < 900 N/mm ²	suitable	90 m/min	M
INOX > 900 N/mm ²	suitable	70 m/min	M
Ti > 850 N/mm ²	suitable only under restricted conditions	40 m/min	S
GG(G)	suitable	85 m/min	K
Uni	suitable		
wet maximum	suitable		
wet minimum	suitable only under restricted conditions		
dry	suitable		
Air	suitable		