

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®.

Tolerance nominal Ø: h10

No. of teeth Z: 3

Helix angle: 40°

Direction of infeed: horizontal, oblique and vertical

Shank: DIN 6535 HB to h6

No. of teeth Z: 3

Flute length L_c : 16 mm

Overhang length L_1 incl. recess: 24 mm

Recess Ø D_1 : 3.9 mm

Overall length L: 62 mm

Shank Ø D_s : 6 mm

Technical description

| | |
|---|----------------------------------|
| Cutting edge Ø D_c | 4 mm |
| Recess Ø D_1 | 3.9 mm |
| Feed f_z for side milling in INOX > 900 N/mm ² | 0.024 mm |
| Direction of infeed | horizontal, oblique and vertical |
| Overhang length L_1 incl. recess | 24 mm |

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|--|-----------------------------|
| Tolerance nominal \varnothing | 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_z for slot milling in stainless steel > 900 N/mm ² | 0.02 mm |
| Flute length L_c | 16 mm |
| Shank $\varnothing D_s$ | 6 mm |
| Helix angle | 40° |
| Corner chamfer angle | 45° |
| 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×D |
| Cutting width a_e for milling operation | 0.3×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 ² | suitable | 240 m/min | P |
| Steel < 750 N/mm ² | suitable | 220 m/min | P |
| Steel < 900 N/mm ² | suitable | 180 m/min | P |

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|--------------------------------|---|-----------|---|
| Steel < 1100 N/mm ² | suitable | 150 m/min | P |
| Steel < 1400 N/mm ² | 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 ² | suitable | 100 m/min | M |
| INOX > 900 N/mm ² | 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 | | |