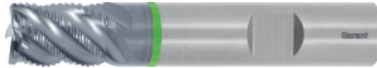


Garant

GARANT Master Steel SlotMachine solid carbide roughing end mill HPC, TiAlN, Ø d11 DC: 4mm



Order data

Order number	205548 4
GTIN	4045197853196
Item class	11X

Description

Version:

With a new-type knurled profile, optimised for higher feed rates. Improved cutting edge protection thanks to slight edge honing. Tremendous bending strength due to the use of ultra-fine grain substrate.

Feed rate per tooth up to 0.1 mm up to a depth of $2 \times D$ (in the slot milled from solid).

Advantage:

The tool geometry produces particularly tightly rolled swarf that is discharged via flat chip breaker recesses. As a result, the tool maintains an extremely stable core. Plunge angle of up to 10° possible thanks to generous recess on the front face.

Application:

For roughing machining, particularly suitable for full-slot machining.

Tolerance nominal \varnothing : d11

No. of teeth Z: 5

Helix angle: 42°

Direction of infeed: horizontal, oblique and vertical

Shank: DIN 6535 HB to h6

No. of teeth Z: 5

Flute length L_c : 8 mm

Overall length L: 54 mm

Shank $\varnothing D_s$: 6 mm

Corner chamfer width at 45° : 0.2 mm

Feed f_z for slot milling in steel $< 900 \text{ N/mm}^2$: 0.03 mm

Technical description

Overall length L	54 mm
Flute length L _c	8 mm
Feed f _z for slot milling in steel < 900 N/mm ²	0.03 mm
No. of teeth Z	5
Shank	DIN 6535 HB to h6
Shank Ø D _s	6 mm
Corner chamfer width at 45°	0.2 mm
Direction of infeed	horizontal, oblique and vertical
Tolerance nominal Ø	d11
Cutting edge Ø D _c	4 mm
Feed f _z for side milling in steel < 900 N/mm ²	0.04 mm
Helix angle	42 °
Corner chamfer angle	45 °
Series	Master Steel
Coating	TiAlN
Tool material	Solid carbide
Standard	DIN 6527
Milling profile	NR
Spacing of the cutters	unequal spacing
Cutting width a _e for milling operation	0.5×D for side milling
Cutting width a _e for milling operation	Full slot cutting depth 1×D
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	200 m/min	P

Steel < 750 N/mm ²	suitable	180 m/min	P
Steel < 900 N/mm ²	suitable	160 m/min	P
Steel < 1100 N/mm ²	suitable	140 m/min	P
Steel < 1400 N/mm ²	suitable	110 m/min	P
INOX < 900 N/mm ²	suitable	50 m/min	M
INOX > 900 N/mm ²	suitable	35 m/min	M
GG(G)	suitable	200 m/min	K
Uni	suitable		
wet maximum	suitable		
wet minimum	suitable only under restricted conditions		
dry	suitable		
Air	suitable		