

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

**Order data**

Order number	202998 4
GTIN	4045197860927
Item class	11X

**Description**
**Version:**

For **roughing and finishing**.

HPC milling cutter with **newly developed high-performance coating** for **outstanding tool life** and **optimum metal removal rate** in a very wide range of stainless steels. **Greater oxidation resistance** and **high-temperature hardness**.

Can be used at **high cutting speeds**, particularly suitable even for TOOLOX®.

**Advantage:**

Particularly low vibration running.

**Technical description**

Shank	DIN 6535 HB to h6
Flute length $L_c$	8 mm
Corner chamfer width at 45°	0.15 mm
Feed $f_z$ for side milling in INOX > 900 N/mm <sup>2</sup>	0.015 mm
Direction of infeed	horizontal, oblique and vertical
Overall length L	54 mm
Feed $f_z$ for slot milling in stainless steel > 900 N/mm <sup>2</sup>	0.012 mm
Cutting edge $\varnothing D_c$	4 mm
Shank $\varnothing D_s$	6 mm
Tolerance nominal $\varnothing$	h10

No. of teeth Z	4
Helix angle	40 degrees
Corner chamfer angle	45 degrees
Series	Master INOX
Coating	TiAlN
Tool material	Solid carbide
Standard	DIN 6527
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	250 m/min	P
Steel < 750 N/mm <sup>2</sup>	suitable	230 m/min	P
Steel < 900 N/mm <sup>2</sup>	suitable	200 m/min	P
Steel < 1100 N/mm <sup>2</sup>	suitable	180 m/min	P
Steel < 1400 N/mm <sup>2</sup>	suitable	115 m/min	P
Steel < 50 HRC	suitable	80 m/min	H
INOX < 900 N/mm <sup>2</sup>	suitable	110 m/min	M
INOX > 900 N/mm <sup>2</sup>	suitable	90 m/min	M
wet maximum	suitable		
wet minimum	suitable		

dry	Suitable only under restricted conditions
Air	suitable