

**Garant**
**Solid carbide forward / reverse corner rounding cutter, TiAlN, Radius r: 1mm**

**Order data**

|              |               |
|--------------|---------------|
| Order number | 208170 1      |
| GTIN         | 4045197198433 |
| Item class   | 11X           |

**Description**
**Version:**
**Extra long shank.**

Double ground head **with quadrant profile.**

**Tolerance:** Size = Radius r  $\pm 0.05$  mm.

**Application:**

For **front** and **back deburring** of edges with contours.

**Technical description**

|  |                        |
|--|------------------------|
| Radius r   | 1 mm                   |
| No. of teeth Z   | 4                      |
| large $\varnothing D_2$                                      | 10 mm                  |
| small $\varnothing D_3$                                      | 8 mm                   |
| $L_2 + 0.5$  | 4 mm                   |
| Feed $f_z$ for side milling in steel < 900 N/mm <sup>2</sup> | 0.01 mm                |
| Shank $\varnothing D_s$                                      | 6 mm                   |
| Overall length L   | 100 mm                 |
| Flute length $L_c$   | 1 mm                   |
| Radius milling   | backwards and forwards |
| Coating  | TiAlN                  |
| Tool material  | Solid carbide          |

|   |                                 |
|---|---------------------------------|
| Standard                                  | Manufacturer's standard         |
| Type                                      | N                               |
| Tolerance of radius contour               | $\pm 0.05$                      |
| Cutting width $a_e$ for milling operation | $0.5 \times r$ for side milling |
| Shank                                     | DIN 6535 HA to h6               |
| Through-coolant                           | no                              |
| Shank tolerance                           | h6                              |
| Colour ring                               | without                         |
| Type of product                           | End mill                        |

### User data

|                                | Suitability                               | $V_c$     | ISO code |
|--------------------------------|---|-----------|----------|
| Aluminium (short chipping)     | suitable                                  | 115 m/min | N        |
| Alu > 10% Si                   | suitable                                  | 70 m/min  | N        |
| Steel < 500 N/mm <sup>2</sup>  | suitable                                  | 65 m/min  | P        |
| Steel < 750 N/mm <sup>2</sup>  | suitable                                  | 65 m/min  | P        |
| Steel < 900 N/mm <sup>2</sup>  | suitable                                  | 40 m/min  | P        |
| Steel < 1100 N/mm <sup>2</sup> | suitable                                  | 35 m/min  | P        |
| INOX < 900 N/mm <sup>2</sup>   | suitable only under restricted conditions | 35 m/min  | M        |
| GG(G)                          | suitable                                  | 40 m/min  | K        |
| Uni                            | suitable only under restricted conditions |           |          |
| wet maximum                    | suitable                                  |           |          |
| wet minimum                    | suitable only under restricted conditions |           |          |
| dry                            | suitable                                  |           |          |
| Air                            | suitable                                  |           |          |

