

Garant
**GARANT Master INOX solid carbide ball nose milling cutter HPC, TiAlN, Ø f8
DC / DS: 4/6mm**

Order data

| | |
|--------------|---------------|
| Order number | 207474 4/6 |
| GTIN | 4062406130442 |
| Item class | 11X |

Description
Version:

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: Radius contour = **±0.005 mm**.

Technical description

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|--|-------------|
| Flute length L_c | 8 mm |
| Shank $\varnothing D_s$ | 6 mm |
| Cutting edge $\varnothing D_c$ | 4 mm |
| Overall length L | 80 mm |
| Feed f_z for side milling in INOX < 900 N/mm ² | 0.012 mm |
| Feed f_z for copy milling in stainless steel < 900 N/mm ² | 0.013 mm |
| No. of teeth Z | 4 |
| Helix angle | 45 degrees |
| Correction factor for v_c | 1.25 |
| Radius R | 2 mm |
| Series | Master INOX |

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|---|----------------------------------|
| Coating | TiAlN |
| Tool material | Solid carbide |
| Standard | Manufacturer's standard |
| Type | N |
| Tolerance nominal \varnothing | f8 |
| Direction of infeed | horizontal, oblique and vertical |
| 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 |
| Shank | DIN 6535 HA to h6 |
| Through-coolant | no |
| Machining strategy | HPC |
| Colour ring | blue |
| Type of product | Ball-nosed slot drill |

User data

| | Suitability | V_c | ISO code |
|--------------------------------|---|-----------|----------|
| Steel < 500 N/mm ² | suitable | 250 m/min | P |
| Steel < 750 N/mm ² | suitable | 230 m/min | P |
| Steel < 900 N/mm ² | suitable | 200 m/min | P |
| Steel < 1100 N/mm ² | suitable | 180 m/min | P |
| Steel < 1400 N/mm ² | suitable | 170 m/min | P |
| TOOLOX 33 | suitable | 115 m/min | H |
| TOOLOX 44 | suitable | 80 m/min | H |
| INOX < 900 N/mm ² | suitable | 110 m/min | M |
| INOX > 900 N/mm ² | suitable | 90 m/min | M |
| Uni | suitable only under restricted conditions | | |
| wet maximum | suitable | | |
| wet minimum | suitable | | |

| | |
|-----------------------------------|---|
| dry | suitable only under restricted conditions |
| Air Services | suitable |
| Shank grinding Type HB | 129100 HB |