

Garant

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



Order data

Order number	207474 4
GTIN	4062406130435
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

Overall length L	80 mm
Flute length L _c	8 mm
Cutting edge Ø D _c	4 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
Feed f _z for side milling in INOX < 900 N/mm ²	0.012 mm
Shank Ø D _s	4 mm
Radius R	2 mm
Series	Master INOX
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	suitable