

Garant

GARANT Master Steel PickPocket solid carbide roughing end mill HPC, TiAlN, Ø f8 DC: 4mm



Order data

Order number	202402 4
GTIN	4062406088064
Item class	11X

Description

Version:

For **roughing and finishing**

With corner radii similar to torus cutters.

Up to 1×D into solid material **at very high feed rates** with smooth cutting action.

Corner radii matched to DIN specifications for **drive keyways**.

Advantage:

Optimised flute form, eccentric relief ground, wide chip space.

Technical description

Flute length L_c	5 mm
Tolerance nominal \varnothing	f8
Helix angle	38 degrees
No. of teeth Z	3
Feed f_z for slot milling in steel < 900 N/mm ²	0.03 mm
Cutting edge $\varnothing D_c$	4 mm
Feed f_z for side milling in steel < 900 N/mm ²	0.04 mm
Shank	DIN 6535 HB to h6
Direction of infeed	horizontal, oblique and vertical
Overall length L	54 mm

Shank $\varnothing D_s$	6 mm
Corner rounding r_v	0.12 mm
Series	Master Steel
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	$0.4 \times D$ for side milling
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	260 m/min	P
Steel < 750 N/mm ²	suitable	240 m/min	P
Steel < 900 N/mm ²	suitable	190 m/min	P
Steel < 1100 N/mm ²	suitable	180 m/min	P
Steel < 1400 N/mm ²	suitable only under restricted conditions	150 m/min	P
INOX < 900 N/mm ²	suitable	80 m/min	M
INOX > 900 N/mm ²	suitable	70 m/min	M
GG(G)	suitable	250 m/min	K
Uni	suitable		
wet maximum	suitable		

wet minimum	suitable only under restricted conditions
dry	suitable
Air	suitable