

**Garant**
**Solid carbide milling cutter HPC, TiAlN, Ø DC: 5 mm**

**Order data**

|              |               |
|--------------|---------------|
| Order number | 203009 5      |
| GTIN         | 4045197588616 |
| Item class   | 11X           |

**Description**
**Version:**

Specially for **machining stainless steels such as duplex steels at high rates of metal removal.**

Cutting edge chamfer: Size 4 = 0.07mm; size 5 – 8 = 0.12 mm; size 10 – 18 = 0.2 mm; ≥ size 20 = 0.3 mm

Tolerance nominal Ø: h10

No. of teeth Z: 4

Helix angle: 38 degrees

Direction of infeed: horizontal, oblique and vertical

Shank: DIN 6535 HB to h6

No. of teeth Z: 4

Flute length  $L_c$ : 13 mm

Overhang length  $L_1$  incl. recess: 19 mm

Recess Ø  $D_1$ : 4.8 mm

Overall length L: 57 mm

Shank Ø  $D_s$ : 6 mm

**Technical description**

|  |          |
|--|----------|
| No. of teeth Z   | 4        |
| Overhang length $L_1$ incl. recess                                     | 19 mm    |
| Corner chamfer width at 45°  | 0.12 mm  |
| Feed $f_z$ for side milling in INOX > 900 N/mm <sup>2</sup>            | 0.03 mm  |
| Cutting edge Ø $D_c$   | 5 mm     |
| Feed $f_z$ for slot milling in stainless steel > 900 N/mm <sup>2</sup> | 0.025 mm |

|   |                                  |
|---|----------------------------------|
| Recess $\varnothing D_1$                  | 4.8 mm                           |
| Shank $\varnothing D_s$                   | 6 mm                             |
| Overall length L                          | 57 mm                            |
| Flute length $L_c$                        | 13 mm                            |
| Direction of infeed                       | horizontal, oblique and vertical |
| Shank                                     | DIN 6535 HB to h6                |
| Tolerance nominal $\varnothing$           | h10                              |
| Helix angle                               | 38 degrees                       |
| Corner chamfer angle                      | 45 degrees                       |
| 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 | 0.3×D for side milling           |
| Cutting width $a_e$ for milling operation | Full slot cutting depth 1×D      |
| Through-coolant                           | no                               |
| Machining strategy                        | HPC                              |
| Colour ring                               | blue                             |
| Type of product                           | End mill                         |