

Garant**GARANT Master Alu solid carbide milling cutter, HPC HPC, DLC, Ø h6 DC: 4mm****Order data**

Order number	203203 4
GTIN	4062406119355
Item class	11X

Description**Version:**

For finishing operations.

Special geometry for optimum chip evacuation.

Unequal spacing gives high intrinsic stability and smooth cutting action.

For profile milling as a finishing operation.

Note:

Order the **uncoated version** using **No. 203207**.

Technical description

Direction of infeed	horizontal
Shank	DIN 6535 HA to h6
Balance quality with shank	G 2.5 with HA
Recess Ø D ₁	3.8 mm
Overhang length L ₁ incl. recess	23 mm
No. of teeth Z	5
Helix angle	38 degrees
Tolerance nominal Ø	h6
Cutting edge Ø D _c	4 mm
Overall length L	65 mm
Shank Ø D _s	6 mm

Data sheet

Flute length L_c	16 mm
Feed f_z for side milling in short-chipping aluminium	0.05 mm
Corner chamfer angle	90 degrees
Series	Master Alu
Coating	DLC
Tool material	Solid carbide
Standard	Manufacturer's standard
Type	W
Spacing of the cutters	unequal spacing
Cutting width a_e for milling operation	$0.1 \times D$ for side milling
Through-coolant	no
Machining strategy	HPC
Colour ring	yellow
Type of product	End / face mill

User data

	Suitability	V_c	ISO code
Aluminium	Suitable	550 m/min	N
Aluminium (short chipping)	suitable	500 m/min	N
Alu > 10% Si	suitable	450 m/min	N
PMMA acrylic	Suitable	200 m/min	N
PE-HD	Suitable	160 m/min	N
PA 66	Suitable	200 m/min	N
PEEK	Suitable	150 m/min	N
PF 31	Suitable	130 m/min	N
PVDF GF20	Suitable	180 m/min	N
POM GF25	Suitable	160 m/min	N
PA 66 GF30	Suitable	150 m/min	N

Data sheet

PEEK GF30	Suitable	130 m/min	N
PTFE CF25	Suitable	160 m/min	N
Honeycomb sandwich	suitable only under restricted conditions	300 m/min	N
Cu	Suitable	160 m/min	N
CuZn	suitable	200 m/min	N
wet maximum	suitable		
wet minimum	suitable only under restricted conditions		
dry	suitable		
Air	suitable		

Suitable products

<https://www.hoffmann-group.com/GB/en/hom/p/203203-4>