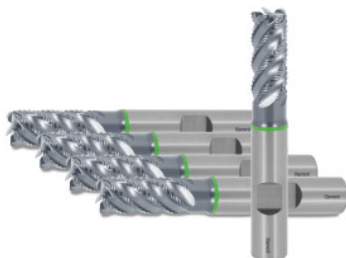


**Garant****Value pack GARANT Master Steel SlotMachine solid carbide roughing end mill HPC, 5 pieces****Order data**

|              |               |
|--------------|---------------|
| Order number | GG1050 4      |
| GTIN         | 4067263134886 |
| Item class   | GGN           |

**Description****Version:**

With a new-type knurled profile, optimised for higher feed rates. Improved cutting edge protection thanks to slight edge honing. Tremendous bending strength due to the use of ultra-fine grain substrate.

Feed rate per tooth up to 0.1 mm up to a depth of  $2 \times D$  (in the slot milled from solid).

**Same as 205550.**

**Advantage:**

The tool geometry produces particularly tightly rolled swarf that is discharged via flat chip breaker recesses. As a result, the tool maintains an extremely stable core. Plunge angle of up to  $10^\circ$  possible thanks to generous recess on the front face.

**Application:**

For roughing machining, particularly suitable for full-slot machining.

**Technical description**

|                                    |            |
|------------------------------------|------------|
| Helix angle                        | 42 degrees |
| Corner chamfer width at $45^\circ$ | 0.2 mm     |
| Tolerance nominal $\varnothing$    | d11        |

## Data sheet

|                                                              |                                  |
|--------------------------------------------------------------|----------------------------------|
| Contents                                                     | 5"                               |
| Feed $f_z$ for slot milling in steel < 900 N/mm <sup>2</sup> | 0.02 mm                          |
| Recess $\varnothing D_1$                                     | 3.7 mm                           |
| Direction of infeed                                          | horizontal, oblique and vertical |
| Corner chamfer angle                                         | 45 degrees                       |
| Shank $\varnothing D_s$                                      | 6 mm                             |
| Overhang length $L_1$ incl. recess                           | 19 mm                            |
| Flute length $L_c$                                           | 11 mm                            |
| Shank                                                        | DIN 6535 HB to h6                |
| Overall length L                                             | 57 mm                            |
| No. of teeth Z                                               | 5                                |
| Feed $f_z$ for side milling in steel < 900 N/mm <sup>2</sup> | 0.03 mm                          |
| Cutting edge $\varnothing D_c$                               | 4 mm                             |
| Series                                                       | Master Steel                     |
| Coating                                                      | TiAlN                            |
| Tool material                                                | Solid carbide                    |
| Standard                                                     | DIN 6527                         |
| Milling profile                                              | NR                               |
| 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                    | 0.3×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 <sup>2</sup> | suitable    | 200 m/min | P        |

## Data sheet

|                                |                                              |           |   |
|--------------------------------|----------------------------------------------|-----------|---|
| Steel < 750 N/mm <sup>2</sup>  | suitable                                     | 180 m/min | P |
| Steel < 900 N/mm <sup>2</sup>  | suitable                                     | 160 m/min | P |
| Steel < 1100 N/mm <sup>2</sup> | suitable                                     | 140 m/min | P |
| Steel < 1400 N/mm <sup>2</sup> | suitable                                     | 110 m/min | P |
| INOX < 900 N/mm <sup>2</sup>   | suitable                                     | 50 m/min  | M |
| INOX > 900 N/mm <sup>2</sup>   | suitable                                     | 35 m/min  | M |
| GG(G)                          | suitable                                     | 200 m/min | K |
| Uni                            | suitable                                     |           |   |
| wet maximum                    | suitable                                     |           |   |
| wet minimum                    | suitable only under<br>restricted conditions |           |   |
| dry                            | suitable                                     |           |   |
| Air                            | suitable                                     |           |   |

### Suitable products

<https://www.hoffmann-group.com/GB/en/hom/p/GG1050-4>