

**Garant****FeedKing high feed rate milling cutter with bore, for indexable inserts XD..****Order data**

|              |               |
|--------------|---------------|
| Order number | 212910 42/4   |
| GTIN         | 4045197320988 |
| Item class   | 210           |

**Description****Version:**

**Dynamic** cutting edge geometry for highest feed rates. Extremely smooth cutting due to **self-stabilising insert bedding**. **Optimised geometry** for reduced cutting forces, thereby reducing the stress on the main spindle.

**Advantage:**

Particularly cost-effective due to **exceptionally sturdy 4-edge** inserts.

**Note:**

Use GARANT torque screwdriver TQ No. **211750 size 3.8** with bit No. **674252 size 15IP**.

**Technical description**

|                                           |         |
|-------------------------------------------|---------|
| Overall length $L_{\text{tot}}$           | 40 mm   |
| $\varnothing D_3$                         | 26 mm   |
| Cutting edge $\varnothing D_c$            | 42 mm   |
| Mounting bore $\varnothing$               | 16 mm   |
| maximum cutting depth $a_{p \text{ max}}$ | 1.15 mm |

|                                                   |                       |
|---------------------------------------------------|-----------------------|
| Set of insert screws                              | 219933 (15IP; 3.8 Nm) |
| suitable indexable insert                         | XD.. 09T308           |
| Number of cutting edges Z                         | 4                     |
| Through-coolant                                   | yes                   |
| Circular interpolation milling Ø D <sub>min</sub> | 68 mm                 |
| Circular interpolation milling Ø D <sub>max</sub> | 82 mm                 |
| Circular interpolation milling a <sub>p</sub>     | 1.15 mm               |
| Ramping length L for α <sub>max</sub>             | 25.5 mm               |
| Ramping angle α <sub>max</sub>                    | 0.67 degrees          |
| Series                                            | FeedKing              |
| Setting angle κ                                   | 9 degrees             |
| Fz Helix                                          | 0.7                   |
| Shank type                                        | with bore             |
| Milling application                               | Circular milling      |
| Milling application                               | Ramping               |
| Milling application                               | Plunging              |
| Spacing of the cutters                            | unequal spacing       |
| Machining strategy                                | HPC                   |
| Tool exchange                                     | PowerCard             |
| Type of product                                   | Copy mill             |

## Suitable products

<https://www.hoffmann-group.com/GB/en/hom/p/212910-42/4>