

Garant
Solid carbide milling cutter HPC, TiAlN, Ø DC: 8Mmm

Order data

Order number	203009 8M
GTIN	4045197657206
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

Technical description

Cutting edge Ø D _c	8 mm
Recess Ø D ₁	7.7 mm
Feed f _z for side milling in INOX > 900 N/mm ²	0.05 mm
Overhang length L ₁ incl. recess	30 mm
No. of teeth Z	4
Corner chamfer width at 45°	0.12 mm
Feed f _z for slot milling in stainless steel > 900 N/mm ²	0.025 mm
Shank Ø D _s	8 mm
Overall length L	68 mm
Flute length L _c	24 mm
Direction of infeed	horizontal, oblique and vertical
Shank	DIN 6535 HB to h6
Tolerance nominal Ø	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 / face mill

User data

	Suitability	V_c	ISO code
INOX < 900 N/mm ²	suitable	110 m/min	M
INOX > 900 N/mm ²	suitable	90 m/min	M
wet maximum	suitable		
wet minimum	suitable		
dry	Suitable only under restricted conditions		
Air	suitable		