

**Garant**
**Solid carbide milling cutter, TiAlN, Ø e8 DC: 8mm**


## Order data

|              |               |
|--------------|---------------|
| Order number | 202556 8      |
| GTIN         | 4067263120636 |
| Item class   | 11X           |

## Description

**Version:**

Double relief ground side clearance angle.

**Note:**
**Successor product to No. 202555.**

## Technical description

|  |                                  |
|--|----------------------------------|
| No. of teeth Z   | 4                                |
| Shank  | DIN 6535 HB to h6                |
| Direction of infeed  | horizontal, oblique and vertical |
| Shank form   | HB                               |
| Corner chamfer width at 45°                                  | 0.08 mm                          |
| Feed $f_z$ for slot milling in steel < 900 N/mm <sup>2</sup> | 0.04 mm                          |
| Cutting edge Ø $D_c$   | 8 mm                             |
| Tolerance nominal Ø  | e8                               |
| Shank Ø $D_s$  | 8 mm                             |
| Flute length $L_c$   | 12 mm                            |
| Helix angle  | 30 degrees                       |
| Overall length L   | 55 mm                            |
| Feed $f_z$ for side milling in steel < 900 N/mm <sup>2</sup> | 0.045 mm                         |

|   |                         |
|---|-------------------------|
| Corner chamfer angle                      | 45 degrees              |
| Coating                                   | TiAlN                   |
| Tool material                             | Solid carbide           |
| Standard                                  | Manufacturer's standard |
| Type                                      | N                       |
| 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                      |
| Colour ring                               | without                 |
| Type of product                           | End / face mill         |

## User data

|                                | Suitability                               | $V_c$     | ISO code |
|--------------------------------|---|-----------|----------|
| Aluminium (short chipping)     | suitable only under restricted conditions | 280 m/min | N        |
| Alu > 10% Si                   | suitable only under restricted conditions | 200 m/min | N        |
| Steel < 500 N/mm <sup>2</sup>  | suitable                                  | 120 m/min | P        |
| Steel < 750 N/mm <sup>2</sup>  | suitable                                  | 105 m/min | P        |
| Steel < 900 N/mm <sup>2</sup>  | suitable                                  | 100 m/min | P        |
| Steel < 1100 N/mm <sup>2</sup> | suitable                                  | 70 m/min  | P        |
| Steel < 1400 N/mm <sup>2</sup> | suitable                                  | 60 m/min  | P        |
| Steel < 55 HRC                 | suitable                                  | 35 m/min  | H        |
| INOX < 900 N/mm <sup>2</sup>   | suitable                                  | 80 m/min  | M        |
| INOX > 900 N/mm <sup>2</sup>   | suitable only under restricted conditions | 60 m/min  | M        |
| GG(G)                          | suitable                                  | 90 m/min  | K        |
| Uni                            | suitable                                  |           |          |
| wet maximum                    | suitable                                  |           |          |

|             |   |
|-------------|---|
| wet minimum | suitable only under restricted conditions |
| dry         | suitable                                  |
| Air         | suitable                                  |