

Garant**GARANT INOX solid carbide milling cutter HPC, AlTiN, Ø e8 DC: 1,5mm****Order data**

Order number	202952 1,5
GTIN	4069515039512
Item class	11Z

Description**Version:**

Milling cutter with **optimised geometry** and modern **high-performance coating** for optimum metal removal rate in various **stainless steels**. Can also be used in **duplex materials**.

Dimensions similar to DIN 6527.

Advantage:

Particularly low vibration running.

Note:

Successor product to 202989.

Technical description

Tolerance nominal Ø	e8
No. of teeth Z	4
Recess Ø D ₁	1.4 mm
Shank form	HA
Shank	DIN 6535 HA to h6
Corner rounding r _v	0.1 mm
Direction of infeed	horizontal, oblique and vertical
Cutting edge Ø D _c	1.5 mm
Helix angle	40 degrees
Shank Ø D _s	4 mm

Data sheet

Flute length L_c	3.5 mm
Overhang length L_1 incl. recess	6 mm
Feed f_z for slot milling in stainless steel $> 900 \text{ N/mm}^2$	0.015 mm
Feed f_z for side milling in INOX $> 900 \text{ N/mm}^2$	0.022 mm
Overall length L	50 mm
Coating	AlTiN
Tool material	Solid carbide
Standard	DIN 6527
Type	N
Spacing of the cutters	unequal spacing
Cutting width a_e for milling operation	$0.3 \times D$ for side milling
Cutting width a_e for milling operation	$0.3 \times D$ for side milling
Through-coolant	no
Machining strategy	HPC
Colour ring	blue
Type of product	End / face mill

User data

	Suitability	V_c	ISO code
Steel $< 500 \text{ N/mm}^2$	suitable only under restricted conditions	240 m/min	P
Steel $< 750 \text{ N/mm}^2$	suitable only under restricted conditions	220 m/min	P
Steel $< 900 \text{ N/mm}^2$	suitable only under restricted conditions	200 m/min	P
Steel $< 1100 \text{ N/mm}^2$	suitable only under restricted conditions	180 m/min	P
Steel $< 1400 \text{ N/mm}^2$	suitable only under restricted conditions	150 m/min	P
TOOLOX 33	suitable only under restricted conditions	115 m/min	H

Data sheet

TOOLOX 44	suitable only under restricted conditions	80 m/min	H
INOX < 900 N/mm ²	suitable	100 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		