

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


## Order data

|              |               |
|--------------|---------------|
| Order number | 201306 8      |
| GTIN         | 4045197862921 |
| Item class   | 11X           |

## Description

### Version:

Dimensions similar to **DIN 6527**.

Improved coating for general-purpose applications in steel and cast iron.

## Technical description

|   |                                  |
|---|----------------------------------|
| Overall length L  | 63 mm                            |
| Flute length $L_c$  | 19 mm                            |
| Recess $\varnothing D_1$                                    | 7.8 mm                           |
| Feed $f_z$ for slot milling in steel $< 750 \text{ N/mm}^2$ | 0.05 mm                          |
| Tolerance nominal $\varnothing$                             | e8                               |
| Direction of infeed   | horizontal, oblique and vertical |
| No. of teeth Z  | 2                                |
| Shank   | DIN 6535 HB to h6                |
| Overhang length $L_1$ incl. recess                          | 27 mm                            |
| Shank $\varnothing D_s$                                     | 8 mm                             |
| Shank form  | HB                               |
| Feed $f_z$ for side milling in steel $< 750 \text{ N/mm}^2$ | 0.08 mm                          |
| Cutting edge $\varnothing D_c$                              | 8 mm                             |
| Helix angle   | 30 degrees                       |

|   |                             |
|---|-----------------------------|
| Corner chamfer angle                      | 90 degrees                  |
| Coating                                   | AlCrN                       |
| Tool material                             | Solid carbide               |
| Standard                                  | DIN 6527                    |
| Type                                      | N                           |
| Cutting width $a_e$ for milling operation | 0.3xD for side milling      |
| Cutting width $a_e$ for milling operation | Full slot cutting depth 1xD |
| 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                                  | 110 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 only under restricted conditions | 60 m/min  | P        |
| INOX < 900 N/mm <sup>2</sup>   | suitable                                  | 70 m/min  | M        |
| INOX > 900 N/mm <sup>2</sup>   | suitable only under restricted conditions | 50 m/min  | M        |
| GG(G)                          | suitable                                  | 90 m/min  | K        |
| Uni                            | suitable                                  |           |          |
| wet maximum                    | suitable                                  |           |          |
| wet minimum                    | suitable                                  |           |          |

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