

Garant
Solid carbide milling cutter, AlCrN, Ø e8 DC: 1,2mm

Order data

Order number	201308 1,2
GTIN	4045197863157
Item class	11X

Description
Version:

Dimensions similar to **DIN 6527**.

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

Note:

Successor product for No. 201630 and 201522.

Technical description

Shank Ø D _s	3 mm
Feed f _z for slot milling in steel < 750 N/mm ²	0.005 mm
No. of teeth Z	2
Flute length L _c	4 mm
Tolerance nominal Ø	e8
Shank	DIN 6535 HA to h6
Corner chamfer width at 45°	0.1 mm
Cutting edge Ø D _c	1.2 mm
Overall length L	50 mm
Feed f _z for side milling in steel < 750 N/mm ²	0.006 mm
Direction of infeed	horizontal, oblique and vertical
Shank form	HA
Helix angle	30 degrees

Corner chamfer angle	45 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 ²	suitable	120 m/min	P
Steel < 750 N/mm ²	suitable	110 m/min	P
Steel < 900 N/mm ²	suitable	100 m/min	P
Steel < 1100 N/mm ²	suitable	70 m/min	P
Steel < 1400 N/mm ²	suitable only under restricted conditions	60 m/min	P
INOX < 900 N/mm ²	suitable	70 m/min	M
INOX > 900 N/mm ²	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