

Garant
Solid carbide mini milling cutter, AlCrN, Ø e8 DC: 4mm

Order data

Order number	202264 4
GTIN	4045197864413
Item class	11X

Description
Version:

 Shank similar to **DIN 6535 HB**.

Save on regrinding costs:

It is cheaper to use solid carbide mini milling cutters to the wear limit than to regrind them. Improved coating for general-purpose applications in steel and cast iron.

Technical description

Shank	HB with h6
Shank Ø D _s	6 mm
No. of teeth Z	3
Tolerance nominal Ø	e8
Feed f _z for slot milling in steel < 750 N/mm ²	0.02 mm
Flute length L _c	7 mm
Feed f _z for side milling in steel < 750 N/mm ²	0.025 mm
Shank form	HB
Overall length L	45 mm
Corner chamfer width at 45°	0.18 mm
Cutting edge Ø D _c	4 mm
Direction of infeed	horizontal, oblique and vertical

Helix angle	45 degrees
Corner chamfer angle	45 degrees
Coating	AlCrN
Tool material	Solid carbide
Standard	Manufacturer's standard
Type	N
Cutting width a_e for milling operation	Full slot cutting depth $1 \times D$
Cutting width a_e for milling operation	Full slot cutting depth $1 \times D$
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