

Garant
Solid carbide milling cutter, AlCrN, Ø e8 DC: 8,5mm


Order data

Order number	202267 8,5
GTIN	4045197865021
Item class	11X

Description

Version:

Dimensions similar to **DIN 6527**.

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

Technical description

Feed f_z for slot milling in steel $< 750 \text{ N/mm}^2$	0.05 mm
Recess $\varnothing D_1$	8.3 mm
Feed f_z for side milling in steel $< 750 \text{ N/mm}^2$	0.08 mm
Flute length L_c	19 mm
Overall length L	72 mm
Cutting edge $\varnothing D_c$	8.5 mm
Direction of infeed	horizontal, oblique and vertical
Shank $\varnothing D_s$	10 mm
No. of teeth Z	3
Overhang length L_1 incl. recess	32 mm
Tolerance nominal \varnothing	e8
Shank	DIN 6535 HA to h6
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	0.3×D for side milling
Cutting width a_e for milling operation	Full slot cutting depth 1×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 Services	suitable
Shank grinding Type HB	129100 HB