

**Garant**
**Solid carbide milling cutter, AlCrN, Ø e8 DC: 3,5mm**

**Order data**

Order number	202290 3,5
GTIN	4045197865793
Item class	11X

**Description**
**Version:**

Dimensions similar to **DIN 6527**.

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

**Technical description**

Recess Ø $D_1$	3.3 mm
Shank Ø $D_s$	6 mm
Overall length L	57 mm
Corner chamfer width at 45°	0.13 mm
Tolerance nominal Ø	e8
Feed $f_z$ for slot milling in steel < 750 N/mm <sup>2</sup>	0.02 mm
No. of teeth Z	3
Shank	DIN 6535 HA to h6
Feed $f_z$ for side milling in steel < 750 N/mm <sup>2</sup>	0.025 mm
Cutting edge Ø $D_c$	3.5 mm
Overhang length $L_1$ incl. recess	15 mm
Flute length $L_c$	11 mm
Direction of infeed	horizontal, oblique and vertical
Helix angle	45 degrees

Corner chamfer angle	45 degrees
Coating	AlCrN
Tool material	Solid carbide
Standard	DIN 6527
Type	N
Cutting width $a_e$ for milling operation	0.5xD 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
<b>Air Services</b>	suitable
Shank grinding Type HB	129100 HB