

Garant
Solid carbide milling cutter, AlCrN, Ø e8 DC: 6mm

Order data

Order number	202294 6
GTIN	4045197866226
Item class	11X

Description
Version:

Dimensions similar to **DIN 6527**.

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

Technical description

Shank Ø D _s	6 mm
Overhang length L ₁ incl. recess	21 mm
Shank form	HB
Tolerance nominal Ø	e8
No. of teeth Z	3
Overall length L	57 mm
Cutting edge Ø D _c	6 mm
Flute length L _c	13 mm
Feed f _z for side milling in steel < 750 N/mm ²	0.05 mm
Feed f _z for slot milling in steel < 750 N/mm ²	0.04 mm
Corner chamfer width at 45°	0.2 mm
Recess Ø D ₁	5.8 mm
Shank	DIN 6535 HB to h6
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	0.5×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	suitable