

**Garant**
**Solid carbide milling cutter, AlCrN, Ø e8 DC: 14mm**

**Order data**

|              |               |
|--------------|---------------|
| Order number | 202294 14     |
| GTIN         | 4045197866325 |
| Item class   | 11X           |

**Description**
**Version:**

Dimensions similar to **DIN 6527**.

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

**Technical description**

|   |                                  |
|---|----------------------------------|
| Cutting edge Ø D <sub>c</sub>   | 14 mm                            |
| Tolerance nominal Ø   | e8                               |
| Recess Ø D <sub>1</sub>   | 13.8 mm                          |
| Corner chamfer width at 45°   | 0.3 mm                           |
| No. of teeth Z  | 3                                |
| Feed f <sub>z</sub> for side milling in steel < 750 N/mm <sup>2</sup> | 0.1 mm                           |
| Shank Ø D <sub>s</sub>  | 14 mm                            |
| Direction of infeed   | horizontal, oblique and vertical |
| Feed f <sub>z</sub> for slot milling in steel < 750 N/mm <sup>2</sup> | 0.07 mm                          |
| Shank   | DIN 6535 HB to h6                |
| Overhang length L <sub>1</sub> incl. recess                           | 38 mm                            |
| Shank form  | HB                               |
| Flute length L <sub>c</sub>   | 26 mm                            |
| Overall length L  | 83 mm                            |

|   |                             |
|---|-----------------------------|
| 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 <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 |
| Air         | suitable                                  |