

**Garant**
**Solid carbide milling cutter, AlCrN, Ø e8 DC: 6,5mm**

**Order data**

Order number	GG1294 6,5
GTIN	4045197907714
Item class	GGN

**Description**
**Version:**

Dimensions similar to **DIN 6527**. Improved coating for general-purpose applications in steel and cast iron.

**Same as No. 202294.**

**Technical description**

No. of teeth Z	3
Direction of infeed	horizontal, oblique and vertical
Shank form	HB
Recess Ø D <sub>1</sub>	6.3 mm
Tolerance nominal Ø	e8
Overall length L	63 mm
Overhang length L <sub>1</sub> incl. recess	27 mm
Cutting edge Ø D <sub>c</sub>	6.5 mm
Flute length L <sub>c</sub>	16 mm

Corner chamfer width at 45°	0.2 mm
Shank	DIN 6535 HB to h6
Feed $f_z$ for side milling in steel < 750 N/mm <sup>2</sup>	0.05 mm
Shank $\varnothing D_s$	8 mm
Feed $f_z$ for slot milling in steel < 750 N/mm <sup>2</sup>	0.04 mm
Helix angle	45 degrees
Corner chamfer angle	45 degrees
Contents	5
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
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		

## Accessories

Solid carbide milling cutter Ø e8 DC 6,5 mm	202294 6,5
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