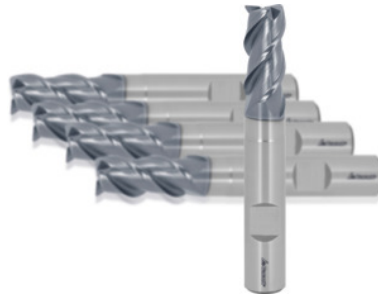


Garant
Solid carbide milling cutter, AlCrN, Ø e8 DC: 8,5mm

Order data

| | |
|--------------|---------------|
| Order number | GG1294 8,5 |
| GTIN | 4045197907752 |
| 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

| | |
|---|----------------------------------|
| Shank form | HB |
| Overall length L | 72 mm |
| Feed f_z for side milling in steel $< 750 \text{ N/mm}^2$ | 0.08 mm |
| Feed f_z for slot milling in steel $< 750 \text{ N/mm}^2$ | 0.05 mm |
| Tolerance nominal \varnothing | e8 |
| Shank | DIN 6535 HB to h6 |
| Direction of infeed | horizontal, oblique and vertical |
| Cutting edge $\varnothing D_c$ | 8.5 mm |
| Shank $\varnothing D_s$ | 10 mm |

| | |
|---|-----------------------------|
| Flute length L_c | 19 mm |
| Overhang length L_1 incl. recess | 32 mm |
| Recess $\varnothing D_1$ | 8.3 mm |
| Corner chamfer width at 45° | 0.3 mm |
| No. of teeth Z | 3 |
| 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 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 | | |

Accessories

Solid carbide milling cutter Ø e8 DC 8,5 mm

202294 8,5