

Garant
Solid carbide milling cutter, AlCrN, Ø e8 DC: 12mm

Order data

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| Order number | 202285 12 |
| GTIN | 4045197931115 |
| Item class | 11X |

Description
Version:

 Dimensions similar to **DIN 6527**.

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

Technical description

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|---|----------------------------------|
| Direction of infeed | horizontal, oblique and vertical |
| Helix angle | 30 degrees |
| Shank Ø D _s | 12 mm |
| Cutting edge Ø D _c | 12 mm |
| Feed f _z for slot milling in steel < 750 N/mm ² | 0.07 mm |
| Shank form | HB |
| Feed f _z for side milling in steel < 750 N/mm ² | 0.1 mm |
| Recess Ø D ₁ | 11.8 mm |
| No. of teeth Z | 3 |
| Shank | DIN 6535 HB to h6 |
| Corner chamfer width at 45° | 0.1 mm |
| Tolerance nominal Ø | e8 |
| Overall length L | 73 mm |
| Flute length L _c | 16 mm |

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| Overhang length L_1 incl. recess | 26 mm |
| Corner chamfer angle | 45 degrees |
| Coating | AlCrN |
| Tool material | Solid carbide |
| Standard | DIN 6527 |
| Type | N |
| Cutting width a_e for milling operation | 0.3×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 | | |

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|-------------|---|
| wet minimum | suitable |
| dry | suitable only under restricted conditions |
| Air | suitable |