

Garant
Solid carbide milling cutter, AlCrN, Ø e8 DC: 4mm


Order data

| | |
|--------------|---------------|
| Order number | 202305 4 |
| GTIN | 4045197931436 |
| Item class | 11X |

Description

Version:

Dimensions similar to **DIN 6527**.

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

Note:

Successor product to No. 202210.

Technical description

| | |
|---|----------------------------------|
| Cutting edge Ø D _c | 4 mm |
| Shank | DIN 6535 HB to h6 |
| Feed f _z for side milling in steel < 750 N/mm ² | 0.025 mm |
| Shank Ø D _s | 6 mm |
| Direction of infeed | horizontal, oblique and vertical |
| Overall length L | 54 mm |
| Tolerance nominal Ø | e8 |
| Overhang length L ₁ incl. recess | 15 mm |
| Flute length L _c | 8 mm |
| Helix angle | 45 degrees |
| Feed f _z for slot milling in steel < 750 N/mm ² | 0.02 mm |
| Shank form | HB |

| | |
|---|-----------------------------|
| No. of teeth Z | 3 |
| Recess $\varnothing D_1$ | 3.8 mm |
| Corner chamfer width at 45° | 0.1 mm |
| Corner chamfer angle | 45 degrees |
| Coating | AlCrN |
| Tool material | Solid carbide |
| Standard | DIN 6527 |
| Type | N |
| Cutting width a_e for milling operation | 0.5×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 |

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