Garant

Solid carbide milling cutter, AlCrN, ∅ e8 DC: 9,5mm

Order data

Order number	202293 9,5
GTIN	4045197931290
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. 202320.

Technical description

Overall length L	72 mm
Cutting edge ∅ D_C	9.5 mm
Corner chamfer width at 45°	0.1 mm
No. of teeth Z	3
Recess ∅ D_1	9.3 mm
Direction of infeed	horizontal, oblique and vertical
Feed f_z for side milling in steel < 750 N/mm^2	0.08 mm
Feed f_z for slot milling in steel < 750 N/mm^2	0.05 mm
Helix angle	45 degrees
Flute length L_c	22 mm
Shank	DIN 6535 HB to h6
Shank ∅ D_s	10 mm
Shank form	HB

Tolerance nominal ∅	e8
Overhang length L_1 incl. recess	32 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/mm²	suitable	120 m/min	P
Steel < 750 N/mm²	suitable	110 m/min	P
Steel < 900 N/mm²	suitable	100 m/min	P
Steel < 1100 N/mm²	suitable	70 m/min	P
Steel < 1400 N/mm²	suitable only under restricted conditions	60 m/min	P
INOX < 900 N/mm²	suitable	70 m/min	M
INOX > 900 N/mm²	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