

Garant
Solid carbide milling cutter, AlCrN, Ø e8 DC: 1,2mm

Order data

Order number	202305 1,2
GTIN	4045197931368
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

Overall length L	38 mm
Corner chamfer width at 45°	0.1 mm
Shank form	HA
Feed f_z for side milling in steel < 750 N/mm ²	0.006 mm
No. of teeth Z	3
Direction of infeed	horizontal, oblique and vertical
Flute length L_c	3 mm
Tolerance nominal Ø	e8
Shank Ø D_s	3 mm
Helix angle	45 degrees
Cutting edge Ø D_c	1.2 mm
Shank	DIN 6535 HA to h6

Feed f_z for slot milling in steel $< 750 \text{ N/mm}^2$	0.005 mm
Corner chamfer angle	45 degrees
Coating	AlCrN
Tool material	Solid carbide
Standard	DIN 6527
Type	N
Cutting width a_e for milling operation	$0.5 \times D$ for side milling
Cutting width a_e for milling operation	Full slot cutting depth $1 \times D$
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 $> 10\% \text{ Si}$	suitable only under restricted conditions	200 m/min	N
Steel $< 500 \text{ N/mm}^2$	suitable	120 m/min	P
Steel $< 750 \text{ N/mm}^2$	suitable	110 m/min	P
Steel $< 900 \text{ N/mm}^2$	suitable	100 m/min	P
Steel $< 1100 \text{ N/mm}^2$	suitable	70 m/min	P
Steel $< 1400 \text{ N/mm}^2$	suitable only under restricted conditions	60 m/min	P
INOX $< 900 \text{ N/mm}^2$	suitable	70 m/min	M
INOX $> 900 \text{ N/mm}^2$	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