

**Garant**
**Solid carbide mini milling cutter, AlCrN, Ø e8 DC: 3,8mm**

**Order data**

|              |               |
|--------------|---------------|
| Order number | 202260 3,8    |
| GTIN         | 4045197930316 |
| Item class   | 11X           |

**Description**
**Version:**

Shank similar to **DIN 6535 HB**.

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

**Save on regrinding costs:**

It is cheaper to use solid carbide mini milling cutters to the wear limit than to regrind them.

**Technical description**

|  |                                  |
|--|----------------------------------|
| Feed $f_z$ for slot milling in steel < 750 N/mm <sup>2</sup> | 0.02 mm                          |
| Shank  | HB with h6                       |
| Shank form   | HB                               |
| Tolerance nominal Ø  | e8                               |
| Corner chamfer width at 45°                                  | 0.18 mm                          |
| Flute length $L_c$   | 7 mm                             |
| Direction of infeed  | horizontal, oblique and vertical |
| No. of teeth Z   | 3                                |
| Cutting edge Ø $D_c$   | 3.8 mm                           |
| Feed $f_z$ for side milling in steel < 750 N/mm <sup>2</sup> | 0.025 mm                         |
| Shank Ø $D_s$  | 6 mm                             |
| Overall length L   | 45 mm                            |

|   |                             |
|---|-----------------------------|
| Helix angle                               | 30 degrees                  |
| Corner chamfer angle                      | 45 degrees                  |
| Coating                                   | AlCrN                       |
| Tool material                             | Solid carbide               |
| Standard                                  | Manufacturer's standard     |
| 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 <sup>2</sup>  | suitable                                  | 120 m/min | P        |
| Steel < 750 N/mm <sup>2</sup>  | suitable                                  | 110 m/min | P        |
| Steel < 900 N/mm <sup>2</sup>  | suitable                                  | 100 m/min | P        |
| Steel < 1100 N/mm <sup>2</sup> | suitable                                  | 70 m/min  | P        |
| Steel < 1400 N/mm <sup>2</sup> | suitable only under restricted conditions | 60 m/min  | P        |
| INOX < 900 N/mm <sup>2</sup>   | suitable                                  | 70 m/min  | M        |
| INOX > 900 N/mm <sup>2</sup>   | 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                                  |