

**Garant**
**Solid carbide milling cutter, AlCrN, Ø e8 DC: 3,5mm**


## Order data

Order number	202285 3,5
GTIN	4045197931023
Item class	11X

## Description

### Version:

Dimensions similar to **DIN 6527**.

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

## Technical description

Helix angle	30 degrees
Corner chamfer width at 45°	0.1 mm
Flute length $L_c$	6 mm
Feed $f_z$ for slot milling in steel < 750 N/mm <sup>2</sup>	0.02 mm
Tolerance nominal Ø	e8
Shank Ø $D_s$	6 mm
Feed $f_z$ for side milling in steel < 750 N/mm <sup>2</sup>	0.025 mm
Shank form	HB
Overall length L	54 mm
Cutting edge Ø $D_c$	3.5 mm
No. of teeth Z	3
Overhang length $L_1$ incl. recess	13 mm
Direction of infeed	horizontal, oblique and vertical
Shank	DIN 6535 HB to h6

Recess $\varnothing D_1$	3.3 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 <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