

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

Order data

Order number	202285 4
GTIN	4045197931030
Item class	11X

Description
Version:

 Dimensions similar to **DIN 6527**.

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

Technical description

Shank Ø D _s	6 mm
Shank	DIN 6535 HB to h6
Cutting edge Ø D _c	4 mm
Helix angle	30 degrees
Shank form	HB
Overhang length L ₁ incl. recess	15 mm
Feed f _z for side milling in steel < 750 N/mm ²	0.025 mm
Direction of infeed	horizontal, oblique and vertical
No. of teeth Z	3
Tolerance nominal Ø	e8
Feed f _z for slot milling in steel < 750 N/mm ²	0.02 mm
Recess Ø D ₁	3.8 mm
Flute length L _c	8 mm
Corner chamfer width at 45°	0.1 mm

Overall length L	54 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 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
Uni	suitable		
wet maximum	suitable		

wet minimum	suitable
dry	suitable only under restricted conditions
Air	suitable