

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

Order number	GG1293 3
GTIN	4045197989499
Item class	GGN

**Description****Version:**

Dimensions similar to **DIN 6527**. Improved coating for general-purpose applications in steel and cast iron.

**Same as No. 202293.**

**Technical description**

Overhang length $L_1$ incl. recess	15 mm
Feed $f_z$ for slot milling in steel $< 750 \text{ N/mm}^2$	0.02 mm
Tolerance nominal $\varnothing$	e8
Flute length $L_c$	8 mm
Shank $\varnothing D_s$	6 mm
Corner chamfer width at $45^\circ$	0.1 mm
Feed $f_z$ for side milling in steel $< 750 \text{ N/mm}^2$	0.025 mm
No. of teeth Z	3
Shank	DIN 6535 HB to h6

Helix angle	45 degrees
Recess $\varnothing D_1$	2.8 mm
Shank form	HB
Cutting edge $\varnothing D_c$	3 mm
Direction of infeed	horizontal, oblique and vertical
Overall length L	57 mm
Corner chamfer angle	45 degrees
Contents	5
Coating	AlCrN
Tool material	Solid carbide
Standard	DIN 6527
Type	N
Cutting width $a_e$ for milling operation	Full slot cutting depth $1 \times D$
Cutting width $a_e$ for milling operation	$0.5 \times D$ for side milling
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		

## Accessories

Solid carbide milling cutter Ø e8 DC 3 mm

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