

Garant
Solid carbide end mill HPC, ZOx, Ø f8 DC: 8mm

Order data

Order number	202549 8
GTIN	4045197454263
Item class	11X

Description
Version:

Sturdy roughing slot drills **without** knuckle profile.

With strong core, **special chip breaker recesses** and **large polished flutes**.

Application:

For roughing milling with high demands on the component surface.

Tolerance nominal Ø: f8

No. of teeth Z: 4

Helix angle: 45 °

Direction of infeed: horizontal, oblique and vertical

Shank: DIN 6535 HA to h6

Balance quality with shank: G 2.5 with HA

No. of teeth Z: 4

Flute length L_c : 24 mm

Overhang length L_1 incl. recess: 30 mm

Recess Ø D_1 : 7.4 mm

Overall length L: 68 mm

Shank Ø D_s : 8 mm

Technical description

Corner chamfer width at 45°	0.2 mm
Shank form	HA
Recess Ø D_1	7.4 mm
Cutting edge Ø D_c	8 mm
Overhang length L_1 incl. recess	30 mm

Feed f_z for side milling in short-chipping aluminium	0.1 mm
No. of teeth Z	4
Feed f_z for slot milling in short-chipping aluminium	0.08 mm
Shank $\varnothing D_s$	8 mm
Overall length L	68 mm
Flute length L_c	24 mm
Direction of infeed	horizontal, oblique and vertical
Shank	DIN 6535 HA to h6
Tolerance nominal \varnothing	f8
Balance quality with shank	G 2.5 with HA
Helix angle	45°
Corner chamfer angle	45°
Coating	ZOX
Tool material	Solid carbide
Standard	Manufacturer's standard
Type	W
Helix angle characteristic	unequal spacing
Spacing of the cutters	unequal spacing
Cutting width a_e for milling operation	0.3×D for side milling
Through-coolant	no
Machining strategy	HPC
Colour ring	yellow
Type of product	End / face mill

User data

	Suitability	V_c	ISO code
Aluminium	suitable only under restricted conditions	500 m/min	N

Aluminium (short chipping)	suitable	480 m/min	N
Alu > 10% Si	suitable	240 m/min	N
Hybrids	suitable only under restricted conditions	m/min	N
Honeycomb sandwich	suitable only under restricted conditions	m/min	N
CuZn	Suitable	240 m/min	N
wet maximum	suitable		
wet minimum	suitable		
dry	suitable only under restricted conditions		
Air	suitable only under restricted conditions		
Services			

Shank recess Type FRST	209900 FRST
Shank grinding Type HB	129100 HB