

Garant
TPC milling head with chip separators 3×D, HB730, Ø D f8: 12mm

Order data

Order number	210344 12
GTIN	4045197722348
Item class	21M

Description
Version:
Milling head specially designed for TPC applications.
Note:
 h_{max} : The values stated in the table are maximum values.

Cutting data for conventional milling can be found in the machining handbook No. 110020.

 $a_{e\ max} = 0.08 \times D$ for TPC machining.

Technical description

Cutter Ø D	12 mm
Head length l	43 mm
Average chip thickness h_{max} for TPC milling in steel < 900 N/mm ²	0.045 mm
Flute length L ₂	36 mm
Corner chamfer width at 45°	0.24 mm
Arbor size	12 mm
Corner chamfer angle	45 degrees
Number of cutting edges Z	5
Series	TopCut
Grade	HB730
Tool material	Solid carbide

Standard	Manufacturer's standard
Type	N
Helix angle	45 degrees
Helix angle characteristic	unequal spacing
Direction of infeed	horizontal, oblique and vertical
Cutting width a_e for milling operation	0,08xD mm
Machining strategy	TPC
Through-coolant	no
suitable arbor	GARANT TopCut
Type of product	Cutter insert for milling

User data

	Suitability	V_c	ISO code
Steel < 500 N/mm ²	suitable	210 m/min	P
Steel < 750 N/mm ²	suitable	170 m/min	P
Steel < 900 N/mm ²	suitable	150 m/min	P
Steel < 1100 N/mm ²	suitable	130 m/min	P
Steel < 1400 N/mm ²	suitable only under restricted conditions	110 m/min	P
Steel < 55 HRC	suitable only under restricted conditions	50 m/min	H
Steel < 60 HRC	suitable only under restricted conditions	40 m/min	H
INOX < 900 N/mm ²	suitable	80 m/min	M
INOX > 900 N/mm ²	suitable only under restricted conditions	50 m/min	M
Ti > 850 N/mm ²	suitable only under restricted conditions	80 m/min	S
GG(G)	suitable	160 m/min	K
Oil	suitable only under restricted conditions		

wet maximum	suitable
wet minimum	suitable only under restricted conditions
dry	suitable only under restricted conditions
Air	suitable