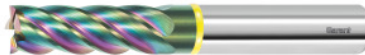


**Garant**
**GARANT Master Alu solid carbide milling cutter, HPC HPC, DLC, Ø h6 DC: 8mm**

**Order data**

|              |               |
|--------------|---------------|
| Order number | 203203 8      |
| GTIN         | 4062406119379 |
| Item class   | 11X           |

**Description**
**Version:**

For finishing operations.

Special geometry for optimum chip evacuation.

Unequal spacing gives high intrinsic stability and smooth cutting action.

For profile milling as a finishing operation.

**Note:**

Order the **uncoated version** using **No. 203207**.

**Technical description**

|   |                   |
|---|-------------------|
| Helix angle   | 38 degrees        |
| Flute length $L_c$                                      | 24 mm             |
| Tolerance nominal $\varnothing$                         | h6                |
| No. of teeth Z  | 5                 |
| Overhang length $L_1$ incl. recess                      | 30 mm             |
| Shank   | DIN 6535 HA to h6 |
| Direction of infeed                                     | horizontal        |
| Shank $\varnothing D_s$                                 | 8 mm              |
| Overall length L  | 70 mm             |
| Balance quality with shank                              | G 2.5 with HA     |
| Feed $f_z$ for side milling in short-chipping aluminium | 0.06 mm           |

|   |                                 |
|---|---------------------------------|
| Cutting edge $\varnothing D_c$            | 8 mm                            |
| Recess $\varnothing D_1$                  | 7.8 mm                          |
| Corner chamfer angle                      | 90 degrees                      |
| Series                                    | Master Alu                      |
| Coating                                   | DLC                             |
| Tool material                             | Solid carbide                   |
| Standard                                  | Manufacturer's standard         |
| Type                                      | W                               |
| Spacing of the cutters                    | unequal spacing                 |
| Cutting width $a_e$ for milling operation | $0.1 \times D$ 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    | 550 m/min | N        |
| Aluminium (short chipping) | suitable    | 500 m/min | N        |
| Alu > 10% Si               | suitable    | 450 m/min | N        |
| PMMA acrylic               | Suitable    | 200 m/min | N        |
| PE-HD                      | Suitable    | 160 m/min | N        |
| PA 66                      | Suitable    | 200 m/min | N        |
| PEEK                       | Suitable    | 150 m/min | N        |
| PF 31                      | Suitable    | 130 m/min | N        |
| PVDF GF20                  | Suitable    | 180 m/min | N        |
| POM GF25                   | Suitable    | 160 m/min | N        |
| PA 66 GF30                 | Suitable    | 150 m/min | N        |

|                    |   |           |   |
|--------------------|---|-----------|---|
| PEEK GF30          | Suitable                                  | 130 m/min | N |
| PTFE CF25          | Suitable                                  | 160 m/min | N |
| Honeycomb sandwich | suitable only under restricted conditions | 300 m/min | N |
| Cu                 | Suitable                                  | 160 m/min | N |
| CuZn               | suitable                                  | 200 m/min | N |
| wet maximum        | suitable                                  |           |   |
| wet minimum        | suitable only under restricted conditions |           |   |
| dry                | suitable                                  |           |   |
| Air                | suitable                                  |           |   |

### Services

Shank grinding Type HB

129100 HB