

Garant
GARANT Master Alu solid carbide milling cutter HPC, DLC, Ø h6 DC: 20mm

Order data

| | |
|--------------|---------------|
| Order number | 203205 20 |
| GTIN | 4062406120023 |
| 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. 203209**.

Technical description

| | |
|---|-------------------|
| Flute length L_c | 100 mm |
| Overhang length L_1 incl. recess | 108 mm |
| Overall length L | 175 mm |
| Shank $\varnothing D_s$ | 20 mm |
| Tolerance nominal \varnothing | h6 |
| Shank | DIN 6535 HA to h6 |
| Direction of infeed | horizontal |
| No. of teeth Z | 5 |
| Recess $\varnothing D_1$ | 19.5 mm |
| Cutting edge $\varnothing D_c$ | 20 mm |
| Feed f_z for side milling in short-chipping aluminium | 0.07 mm |

| | |
|---|----------------------------------|
| Helix angle | 38 degrees |
| Balance quality with shank | G 2.5 with HA |
| 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 | $0.05 \times D$ 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 | 500 m/min | N |
| Aluminium (short chipping) | suitable | 450 m/min | N |
| Alu > 10% Si | suitable | 400 m/min | N |
| PMMA acrylic | Suitable | 180 m/min | N |
| PE-HD | Suitable | 140 m/min | N |
| PA 66 | Suitable | 180 m/min | N |
| PEEK | Suitable | 130 m/min | N |
| PF 31 | Suitable | 110 m/min | N |
| PVDF GF20 | Suitable | 160 m/min | N |
| POM GF25 | Suitable | 140 m/min | N |
| PA 66 GF30 | Suitable | 140 m/min | N |

| | | | |
|--------------------|---|-----------|---|
| PEEK GF30 | Suitable | 120 m/min | N |
| PTFE CF25 | Suitable | 140 m/min | N |
| Honeycomb sandwich | suitable only under restricted conditions | 260 m/min | N |
| Cu | Suitable | 140 m/min | N |
| CuZn | suitable | 120 m/min | N |
| wet maximum | suitable | | |
| wet minimum | suitable only under restricted conditions | | |
| dry | suitable | | |
| Air | suitable | | |

Services

Shank grinding Type HB

129100 HB