

Garant
Solid carbide roughing end mill MTC, AlCrN, Ø e8 DC: 20mm

Order data

Order number	203071 20
GTIN	4045197776105
Item class	11X

Description
Version:

For **roughing and finishing** up to $0.7 \times D$ into solid material **at very high feed rates** with smooth cutting action.

For cutting force reduction and better surface quality due to **45° helix**.

Improved coating for a further reduction in cutting force combined with increased tool life.

Application:

Especially for **MTC (Multi Task Cutting)** use on the new generation of turning / milling centres.

Technical description

Feed f_z for side milling in steel $< 900 \text{ N/mm}^2$	0.08 mm
Overall length L	150 mm
Overhang length L_1 incl. recess	98 mm
Flute length L_c	41 mm
Shank $\varnothing D_s$	20 mm
Balance quality with shank	G 2.5 with HB
Cutting edge $\varnothing D_c$	20 mm
Direction of infeed	horizontal, oblique and vertical
Tolerance nominal \varnothing	e8
Feed f_z for slot milling in steel $< 900 \text{ N/mm}^2$	0.06 mm
Corner chamfer width at 45°	0.3 mm

Recess $\varnothing D_1$	19.5 mm
No. of teeth Z	4
Shank	DIN 6535 HB to h6
Helix angle	45 degrees
Corner chamfer angle	45 degrees
Coating	AlCrN
Tool material	solid carbide
Standard	Manufacturer's standard
Type	N
Helix angle characteristic	unequal spacing
Spacing of the cutters	unequal spacing
Cutting width a_e for milling operation	0.1×D for side milling
Cutting width a_e for milling operation	Full slot cutting depth 1×D
Through-coolant	no
Machining strategy	MTC
Colour ring	green
Type of product	End / face mill

User data

	Suitability	V_c	ISO code
Steel < 500 N/mm ²	suitable	100 m/min	P
Steel < 750 N/mm ²	suitable	90 m/min	P
Steel < 900 N/mm ²	suitable	85 m/min	P
Steel < 1100 N/mm ²	suitable	80 m/min	P
INOX < 900 N/mm ²	suitable	40 m/min	M
INOX > 900 N/mm ²	suitable	30 m/min	M
GG(G)	suitable	100 m/min	K
Uni	suitable		
wet maximum	suitable		

wet minimum	suitable only under restricted conditions
dry	suitable
Air	suitable