

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

Order data

Order number	202470 20
GTIN	4062406245733
Item class	11X

Description
Version:
Extra sharp cutting edges.

Dimensions similar to DIN 6527.

Double relief ground side clearance angle.

For roughing and finishing. Up to 2×D into solid material at very high feed rates and smooth cutting action.

Note:

Successor product to No. 202480.

Technical description

Overhang length L_1 incl. recess	51 mm
Flute length L_c	41 mm
Direction of infeed	horizontal, oblique and vertical
Feed f_z for slot milling in short-chipping aluminium	0.18 mm
No. of teeth Z	4
Cutting edge $\varnothing D_c$	20 mm
Overall length L	104 mm
Feed f_z for side milling in short-chipping aluminium	0.22 mm
Shank $\varnothing D_s$	20 mm
Recess $\varnothing D_1$	19 mm

Tolerance nominal \varnothing	h6
Shank	DIN 6535 HA to h6
Helix angle	38 degrees
Corner chamfer angle	90 degrees
Series	Master Alu
Coating	uncoated
Tool material	Solid carbide
Standard	DIN 6527
Type	W
Cutting width a_e for milling operation	Full slot cutting depth $1 \times D$
Cutting width a_e for milling operation	Full slot cutting depth $1 \times D$
Through-coolant	no
Machining strategy	HPC
Colour ring	yellow
Type of product	End / face mill

User data

	Suitability	V_c	ISO code
Aluminium	Suitable	250 m/min	N
Aluminium (short chipping)	suitable	200 m/min	N
Alu > 10% Si	suitable	180 m/min	N
PMMA acrylic	Suitable	180 m/min	N
PE-HD	Suitable	130 m/min	N
PA 66	Suitable	150 m/min	N
PEEK	Suitable	130 m/min	N
PF 31	Suitable	110 m/min	N
Honeycomb sandwich	suitable only under restricted conditions	180 m/min	N

Cu	Suitable	120 m/min	N
CuZn	Suitable	150 m/min	N
wet maximum	suitable		
wet minimum	suitable only under restricted conditions		
dry	suitable only under restricted conditions		
Air	suitable only under restricted conditions		
Services			

Shank grinding Type HB	129100 HB
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