

Garant
Solid carbide milling cutter with chip separators TPC, TiAlN, Ø f8 DC: 12mm

Order data

Order number	203019 12
GTIN	4045197609762
Item class	11X

Description
Version:

High-performance mills for machining stainless steels, **especially designed for TPC applications**. Strengthened core.

Note:

h_{max} : The values stated in the table are maximum values.

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

NEW GENERATION AVAILABLE!

Recommended successor product is No. 203103

Technical description

Corner chamfer width at 45°	0.24 mm
No. of teeth Z	5
Cutting edge Ø D_c	12 mm
Average chip thickness h_{max} for TPC milling in INOX < 900 N/mm ²	0.07 mm
Recess Ø D_1	11.8 mm
Average chip thickness h_{max} for TPC milling in INOX > 900 N/mm ²	0.06 mm
Overhang length L_1 incl. recess	45 mm
Shank Ø D_s	12 mm
Overall length L	93 mm

Flute length L_c	36 mm
Direction of infeed	horizontal and oblique
Shank	DIN 6535 HB to h6
Tolerance nominal \varnothing	f8
Balance quality with shank	G 2.5 with HB
Helix angle	45 degrees
Corner chamfer angle	45 degrees
Coating	TiAlN
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	$0.08 \times D$
Through-coolant	no
Machining strategy	TPC
Colour ring	blue
Type of product	End / face mill

User data

	Suitability	V_c	ISO code
Steel < 500 N/mm ²	suitable	380 m/min	P
Steel < 750 N/mm ²	suitable	340 m/min	P
Steel < 900 N/mm ²	suitable	300 m/min	P
Steel < 1100 N/mm ²	suitable	230 m/min	P
INOX < 900 N/mm ²	suitable	240 m/min	M
INOX > 900 N/mm ²	suitable	170 m/min	M
wet maximum	Suitable		

wet minimum	Suitable only under restricted conditions
Air	suitable