

**Garant**
**GARANT Master Alu solid carbide milling cutter, HPC HPC, uncoated, Ø e8 DC: 20mm**

**Order data**

Order number	203207 20
GTIN	4062406565909
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.

**Technical description**

Flute length $L_c$	60 mm
Shank $\varnothing D_s$	20 mm
Tolerance nominal $\varnothing$	h6
Shank	DIN 6535 HA to h6
Corner chamfer angle	90 degrees
No. of teeth Z	5
Feed $f_z$ for side milling in short-chipping aluminium	0.09 mm
Overall length L	125 mm
Helix angle	38 degrees
Recess $\varnothing D_1$	19.5 mm
Balance quality with shank	G 2.5 with HA
Cutting edge $\varnothing D_c$	20 mm

Direction of infeed	horizontal
Overhang length $L_1$ incl. recess	70 mm
Series	Master Alu
Coating	uncoated
Tool material	Solid carbide
Standard	Manufacturer's standard
Type	W
Spacing of the cutters	unequal spacing
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	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