

**Garant**
**Solid carbide milling cutter with chip separators TPC, TiAlN, Ø f8 DC: 8 mm**

**Order data**

Order number	203083 8
GTIN	4045197609908
Item class	11X

**Description**
**Version:**

High-performance miller for machining superalloys, **especially designed for TPC applications.**  
Strengthened core.

**Note:**

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

$a_{e \max} = 0.06 \times D$  for TPC machining.

Tolerance nominal Ø: f8

No. of teeth Z: 5

Helix angle: 45 degrees

Direction of infeed: horizontal and oblique

Shank: DIN 6535 HB to h6

Balance quality with shank: G 2.5 with HB

No. of teeth Z: 5

Flute length  $L_c$ : 24 mm

Overhang length  $L_1$  incl. recess: 30 mm

Recess Ø  $D_1$ : 7.8 mm

Overall length L: 68 mm

Shank Ø  $D_s$ : 8 mm

**Technical description**

Overhang length $L_1$ incl. recess	30 mm
Recess Ø $D_1$	7.8 mm
Cutting edge Ø $D_c$	8 mm
Average chip thickness $h_{\max}$ for TPC milling in Inconel®	0.04 mm

Average chip thickness $h_{\max}$ for TPC milling in titanium > 850 N/mm <sup>2</sup>	0.045 mm
No. of teeth Z	5
Shank $\varnothing D_s$	8 mm
Overall length L	68 mm
Flute length $L_c$	24 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 rounding $r_v$	0.2 mm
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	0.06×D
Through-coolant	no
Machining strategy	TPC
Colour ring	pink
Type of product	End mill

## Services

Shank recess Type FRST	209900 FRST
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