

Garant
Solid carbide milling cutter DIN 6535 HA, TiAlN, Ø e8 DC: 20mm

Order data

Order number	203440 20
GTIN	4045197119520
Item class	11X

Description
Version:

High stability and **extremely smooth cutting action**
due to at least 6 teeth.

Double relief ground clearance angle.

Application:

For peripheral milling as a **finishing operation.**

Technical description

Feed f_z for side milling in steel $< 900 \text{ N/mm}^2$	0.107 mm
Overhang length L_1 incl. recess	48 mm
Corner chamfer width at 45°	0.05 mm
Cutting edge $\varnothing D_c$	20 mm
Recess $\varnothing D_1$	19.8 mm
No. of teeth Z	8
Shank $\varnothing D_s$	20 mm
Overall length L	104 mm
Flute length L_c	38 mm
Direction of infeed	horizontal
Shank	DIN 6535 HA to h6
Tolerance nominal \varnothing	e8

Helix angle	45 degrees
Corner chamfer angle	45 degrees
Coating	TiAlN
Tool material	Solid carbide
Standard	DIN 6527
Type	N
Cutting width a_e for milling operation	$0.1 \times D$ for side milling
Through-coolant	no
Colour ring	green
Type of product	End / face mill

User data

	Suitability	V_c	ISO code
Aluminium (short chipping)	suitable only under restricted conditions	600 m/min	N
Alu > 10% Si	suitable only under restricted conditions	400 m/min	N
Steel < 500 N/mm ²	suitable	190 m/min	P
Steel < 750 N/mm ²	suitable	170 m/min	P
Steel < 900 N/mm ²	suitable	160 m/min	P
Steel < 1100 N/mm ²	suitable	95 m/min	P
Steel < 1400 N/mm ²	suitable	85 m/min	P
Steel < 55 HRC	suitable only under restricted conditions	65 m/min	H
INOX < 900 N/mm ²	suitable	90 m/min	M
INOX > 900 N/mm ²	suitable	75 m/min	M
Ti > 850 N/mm ²	suitable only under restricted conditions	60 m/min	S
GG(G)	suitable	120 m/min	K
Uni	suitable		

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