

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

**Order data**

Order number	203480 20
GTIN	4045197119636
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**

Cutting edge Ø D <sub>c</sub>	20 mm
Corner chamfer width at 45°	0.05 mm
Overhang length L <sub>1</sub> incl. recess	48 mm
No. of teeth Z	8
Recess Ø D <sub>1</sub>	19.8 mm
Feed f <sub>z</sub> for side milling in steel < 900 N/mm <sup>2</sup>	0.107 mm
Shank Ø D <sub>s</sub>	20 mm
Overall length L	104 mm
Flute length L <sub>c</sub>	38 mm
Direction of infeed	horizontal
Shank	DIN 6535 HB to h6
Tolerance nominal Ø	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×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 <sup>2</sup>	suitable	190 m/min	P
Steel < 750 N/mm <sup>2</sup>	suitable	170 m/min	P
Steel < 900 N/mm <sup>2</sup>	suitable	160 m/min	P
Steel < 1100 N/mm <sup>2</sup>	suitable	95 m/min	P
Steel < 1400 N/mm <sup>2</sup>	suitable	85 m/min	P
Steel < 55 HRC	suitable only under restricted conditions	65 m/min	H
INOX < 900 N/mm <sup>2</sup>	suitable	90 m/min	M
INOX > 900 N/mm <sup>2</sup>	suitable	75 m/min	M
Ti > 850 N/mm <sup>2</sup>	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