

**Garant**
**Solid carbide milling cutter with chip separators TPC, TiAlN, Ø f8 DC: 16mm**

**Order data**

Order number	203105 16
GTIN	4045197814746
Item class	11X

**Description**
**Version:**

High-performance milling cutter with **irregular cutter spacing** and **irregular helical pitch**.  
Optimised bending strength due to the use of ultra-fine grain substrates.  
Offset chip separators.

**Note:**

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

$a_{e\ max} = 0.03 \times D$  for TPC machining.

Tolerance nominal Ø: f8

No. of teeth Z: 7

Helix angle: 40°

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: 7

Flute length  $L_c$ : 80 mm

Overall length L: 136 mm

Shank Ø  $D_s$ : 16 mm

Corner chamfer width at 45°: 0.32 mm

Average chip thickness  $h_{max}$  for TPC milling in INOX < 900 N/mm<sup>2</sup>: 0.057 mm

**Technical description**

Corner chamfer width at 45°	0.32 mm
Balance quality with shank	G 2.5 with HB
Shank Ø $D_s$	16 mm

Direction of infeed	horizontal and oblique
Flute length $L_c$	80 mm
Overall length $L$	136 mm
No. of teeth $Z$	7
Shank	DIN 6535 HB to h6
Tolerance nominal $\varnothing$	f8
Cutting edge $\varnothing D_c$	16 mm
Helix angle	40°
Average chip thickness $h_{max}$ for TPC milling in INOX < 900 N/mm <sup>2</sup>	0.057 mm
Corner chamfer angle	45°
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	0.03×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 <sup>2</sup>	suitable	270 m/min	P
Steel < 750 N/mm <sup>2</sup>	suitable	240 m/min	P
Steel < 900 N/mm <sup>2</sup>	suitable	210 m/min	P
Steel < 1100 N/mm <sup>2</sup>	suitable	160 m/min	P

INOX < 900 N/mm <sup>2</sup>	suitable	200 m/min	M
INOX > 900 N/mm <sup>2</sup>	suitable	140 m/min	M
wet maximum	Suitable		
wet minimum	Suitable only under restricted conditions		
Air	suitable		

**Services**

Shank clamping flats for shrink-fit chucks, with retainer function Shank Ø tool 16 mm

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