

**Garant**
**Solid carbide milling cutter TPC, TiAlN, Ø f8 DC: 20mm**

**Order data**

Order number	203102 20
GTIN	4045197814524
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 breaker.

Note:

$a_e \max = 0.1 \times D$  for TPC machining. NEW GENERATION AVAILABLE! Recommended successor product is No. 203116.  $h_{\max}$ : The values stated in the table are maximum values. For finishing operations we recommend items No. 204012, 204014 and 204015.

**Technical description**

Shank Ø $D_s$	20 mm
Balance quality with shank	G 2.5 with HB
Corner chamfer width at 45°	0.4 mm
Direction of infeed	horizontal and oblique
Flute length $L_c$	41 mm
Overhang length $L_1$ incl. recess	52 mm
Recess Ø $D_1$	19.8 mm
Overall length $L$	104 mm
Cutting edge Ø $D_c$	20 mm
Shank	DIN 6535 HB to h6
No. of teeth $Z$	7

Tolerance nominal $\varnothing$	f8
Helix angle	40 degrees
Average chip thickness $h_{\max}$ for TPC milling in INOX < 900 N/mm <sup>2</sup>	0.105 mm
Corner chamfer angle	45 degrees
Number of chip separators	0
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	0.1×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	380 m/min	P
Steel < 750 N/mm <sup>2</sup>	suitable	340 m/min	P
Steel < 900 N/mm <sup>2</sup>	suitable	300 m/min	P
Steel < 1100 N/mm <sup>2</sup>	suitable	230 m/min	P
INOX < 900 N/mm <sup>2</sup>	suitable	240 m/min	M
INOX > 900 N/mm <sup>2</sup>	suitable	170 m/min	M
wet maximum	Suitable		
wet minimum	Suitable only under restricted conditions		

Air

suitable