

Garant
Solid carbide milling cutter TPC, TiAlN, Ø f8 DC: 16mm

Order data

Order number	203102 16
GTIN	4045197814517
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:

ae max= 0.1×D for TPC machining. NEW GENERATION AVAILABLE! Recommended successor product is No. 203116. hmax: The values stated in the table are maximum values. For finishing operations we recommend items No. 204012, 204014 and 204015.

Technical description

Cutting edge Ø D _c	16 mm
Shank	DIN 6535 HB to h6
Overall length L	92 mm
Shank Ø D _s	16 mm
Direction of infeed	horizontal and oblique
Tolerance nominal Ø	f8
Overhang length L ₁ incl. recess	42 mm
Flute length L _c	32 mm
Balance quality with shank	G 2.5 with HB
No. of teeth Z	7
Recess Ø D ₁	15.8 mm

Corner chamfer width at 45°	0.32 mm
Helix angle	40 degrees
Average chip thickness h_{\max} for TPC milling in INOX < 900 N/mm ²	0.085 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 ²	suitable	380 m/min	P
Steel < 750 N/mm ²	suitable	340 m/min	P
Steel < 900 N/mm ²	suitable	300 m/min	P
Steel < 1100 N/mm ²	suitable	230 m/min	P
INOX < 900 N/mm ²	suitable	240 m/min	M
INOX > 900 N/mm ²	suitable	170 m/min	M
wet maximum	Suitable		
wet minimum	Suitable only under restricted conditions		

Air

suitable