

**Garant**
**Solid carbide milling cutter TPC, TiAlN, Ø f8 DC: 10mm**

**Order data**

Order number	203102 10
GTIN	4045197814494
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**

Corner chamfer width at 45°	0.2 mm
No. of teeth Z	7
Direction of infeed	horizontal and oblique
Overhang length L <sub>1</sub> incl. recess	30 mm
Shank Ø D <sub>s</sub>	10 mm
Flute length L <sub>c</sub>	22 mm
Balance quality with shank	G 2.5 with HB
Recess Ø D <sub>1</sub>	9.8 mm
Overall length L	72 mm
Tolerance nominal Ø	f8
Cutting edge Ø D <sub>c</sub>	10 mm

Shank	DIN 6535 HB to h6
Helix angle	40 degrees
Average chip thickness $h_{\max}$ for TPC milling in INOX < 900 N/mm <sup>2</sup>	0.055 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