Garant

Solid carbide milling cutter TPC, TiAlN, ⌀ f8 DC: 8mm

Order data

Order number	203102 8
GTIN	4045197814487
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

Direction of infeed	horizontal and oblique
Overhang length L_1 incl. recess	25 mm
Cutting edge ⌀ D_C	8 mm
Corner chamfer width at 45°	0.16 mm
Overall length L	63 mm
Balance quality with shank	G 2.5 with HB
Recess ⌀ D_1	7.8 mm
Flute length L_c	19 mm
Shank ⌀ D_s	8 mm
No. of teeth Z	7
Shank	DIN 6535 HB to h6

Tolerance nominal ∅	f8
Helix angle	40 degrees
Average chip thickness h_{max} for TPC milling in INOX < 900 N/mm²	0.045 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/mm²	suitable	380 m/min	P
Steel < 750 N/mm²	suitable	340 m/min	P
Steel < 900 N/mm²	suitable	300 m/min	P
Steel < 1100 N/mm²	suitable	230 m/min	P
INOX < 900 N/mm²	suitable	240 m/min	M
INOX > 900 N/mm²	suitable	170 m/min	M
wet maximum	Suitable		
wet minimum	Suitable only under restricted conditions		

Air	suitable