

**Garant**
**Solid carbide milling cutter, uncoated, Ø e8 DC: 20mm**

**Order data**

Order number	202640 20
GTIN	4045197117717
Item class	11X

**Description**
**Version:**

Double relief ground side clearance angle.

**Technical description**

Feed $f_z$ for side milling in steel < 900 N/mm <sup>2</sup>	0.12 mm
No. of teeth Z	4
Shank form	HB
Recess Ø $D_1$	19.8 mm
Feed $f_z$ for slot milling in steel < 900 N/mm <sup>2</sup>	0.1 mm
Cutting edge Ø $D_c$	20 mm
Overhang length $L_1$ incl. recess	50 mm
Corner chamfer width at 45°	0.2 mm
Shank Ø $D_s$	20 mm
Overall length L	104 mm
Flute length $L_c$	40 mm
Direction of infeed	horizontal, oblique and vertical
Shank	DIN 6535 HB to h6
Tolerance nominal Ø	e8
Helix angle	30 degrees

Corner chamfer angle	45 degrees
Coating	uncoated
Tool material	Solid carbide
Standard	Manufacturer's standard
Type	N
Cutting width $a_e$ for milling operation	0.3×D for side milling
Cutting width $a_e$ for milling operation	Full slot cutting depth 1×D
Through-coolant	no
Colour ring	without
Type of product	End / face mill

## User data

	Suitability	$V_c$	ISO code
Aluminium (short chipping)	suitable only under restricted conditions	140 m/min	N
Alu > 10% Si	suitable only under restricted conditions	105 m/min	N
Steel < 500 N/mm <sup>2</sup>	suitable	70 m/min	P
Steel < 750 N/mm <sup>2</sup>	suitable	60 m/min	P
Steel < 900 N/mm <sup>2</sup>	suitable	55 m/min	P
Steel < 1100 N/mm <sup>2</sup>	suitable	35 m/min	P
Steel < 1400 N/mm <sup>2</sup>	suitable	30 m/min	P
Steel < 55 HRC	suitable only under restricted conditions	25 m/min	H
INOX < 900 N/mm <sup>2</sup>	suitable	40 m/min	M
INOX > 900 N/mm <sup>2</sup>	suitable only under restricted conditions	30 m/min	M
GG(G)	suitable	55 m/min	K
Uni	suitable		
wet maximum	suitable		

wet minimum	Suitable only under restricted conditions
dry	suitable only under restricted conditions
Air	Suitable only under restricted conditions