

Garant
PCD milling cutter with internal cooling HPC, PCD, Ø DC: 20mm

Order data

Order number	209808 20
GTIN	4067263101130
Item class	11Y

Description
Version:

High-performance PCD milling cutter designed for **high-volume machining**. **High rigidity** due to conical design. Very well suited for structural components made of aluminium. Axial angle approx. 10° positive. Taper transition with 1.5° (angle α).

Technical description

Flute length L_c	14.2 mm
Recess $\varnothing D_1$	17 mm
Cutting edge $\varnothing D_c$	20 mm
$\varnothing D_2$	19.4 mm
Overall length L	120 mm
L_2	70 mm
No. of teeth Z	3
Corner radius R_1	3 mm
Shank $\varnothing D_s$	20 mm
Overhang length L_1 incl. recess	22.6 mm
Feed f_z for slot milling in cast aluminium	0.2 mm
Shank	DIN 6535 HA to h6
Coating	PCD

Tool material	PCD
Standard	Works standard
Type	N
Tolerance nominal \varnothing	± 0.05
Direction of infeed	horizontal, oblique and vertical
Cutting width a_e for milling operation	$0.3 \times D$ for side milling
Through-coolant	yes
Machining strategy	HPC
Colour ring	yellow
Type of product	Torus cutter

User data

	Suitability	V_c	ISO code
Aluminium	suitable	900 m/min	N
Aluminium (short chipping)	suitable	900 m/min	N
Alu > 10% Si	suitable	900 m/min	N
PMMA acrylic	suitable	1000 m/min	N
PE-HD	suitable	1000 m/min	N
PA 66	suitable only under restricted conditions	1000 m/min	N
PEEK	suitable only under restricted conditions	1000 m/min	N
PF 31	suitable only under restricted conditions	1000 m/min	N
AFRP aramid	suitable only under restricted conditions	1000 m/min	N
PVDF GF20	suitable only under restricted conditions	1000 m/min	N
POM GF25	suitable only under restricted conditions	1000 m/min	N

PA 66 GF30	suitable only under restricted conditions	1000 m/min	N
PEEK GF30	suitable only under restricted conditions	1000 m/min	N
PTFE CF25	suitable only under restricted conditions	1000 m/min	N
PEEK CF30	suitable only under restricted conditions	1000 m/min	N
Cu	suitable	900 m/min	N
CuZn	suitable	900 m/min	N
Oil	suitable		
wet maximum	suitable		
wet minimum	suitable		
dry	suitable		
Air	suitable		