

Garant**GARANT INOX solid carbide milling cutter HPC, AlTiN, Ø e8 DC: 20mm****Order data**

Order number	202952 20
GTIN	4069515039628
Item class	11Z

Description**Version:**

Milling cutter with **optimised geometry** and modern **high-performance coating** for optimum metal removal rate in various **stainless steels**. Can also be used in **duplex materials**.

Dimensions similar to DIN 6527.

Advantage:

Particularly low vibration running.

Note:

Successor product to 202989.

Technical description

Flute length L_c	41 mm
Feed f_z for slot milling in stainless steel $> 900 \text{ N/mm}^2$	0.09 mm
Shank $\varnothing D_s$	20 mm
Shank	DIN 6535 HB to h6
Helix angle	40 degrees
Recess $\varnothing D_1$	19.5 mm
Tolerance nominal $\varnothing$	e8
Feed f_z for side milling in INOX $> 900 \text{ N/mm}^2$	0.1 mm
Overhang length L_1 incl. recess	52 mm
Direction of infeed	horizontal, oblique and vertical

Data sheet

Shank form	HB
Cutting edge $\varnothing D_c$	20 mm
Corner rounding r_v	0.2 mm
Overall length L	104 mm
No. of teeth Z	4
Coating	AlTiN
Tool material	Solid carbide
Standard	DIN 6527
Type	N
Spacing of the cutters	unequal spacing
Cutting width a_e for milling operation	0.3×D for side milling
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Through-coolant	no
Machining strategy	HPC
Colour ring	blue
Type of product	End / face mill

User data

	Suitability	V_c	ISO code
Steel < 500 N/mm ²	suitable only under restricted conditions	240 m/min	P
Steel < 750 N/mm ²	suitable only under restricted conditions	220 m/min	P
Steel < 900 N/mm ²	suitable only under restricted conditions	200 m/min	P
Steel < 1100 N/mm ²	suitable only under restricted conditions	180 m/min	P
Steel < 1400 N/mm ²	suitable only under restricted conditions	150 m/min	P
TOOLOX 33	suitable only under restricted conditions	115 m/min	H

Data sheet

TOOLOX 44	suitable only under restricted conditions	80 m/min	H
INOX < 900 N/mm ²	suitable	100 m/min	M
INOX > 900 N/mm ²	suitable	90 m/min	M
wet maximum	suitable		
wet minimum	suitable		
dry	suitable only under restricted conditions		
Air	suitable		