

Garant
Solid carbide milling cutter HPC, TiAlN, Ø e8 DC: 20mm

Order data

Order number	203024 20
GTIN	4045197857941
Item class	11X

Description
Note:

Successor product to No. 203022.

Technical description

Shank	DIN 6535 HB to h6
Overall length L	175 mm
No. of teeth Z	4
Cutting edge Ø D _c	20 mm
Feed f _z for side milling in INOX > 900 N/mm ²	0.1 mm
Flute length L _c	102 mm
Tolerance nominal Ø	e8
Corner chamfer width at 45°	0.5 mm
Direction of infeed	horizontal, oblique and vertical
Shank Ø D _s	20 mm
Helix angle	38 degrees
Corner chamfer angle	45 degrees
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	$0.1 \times D$ for side milling
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	100 m/min	P
Steel < 750 N/mm ²	suitable	90 m/min	P
Steel < 900 N/mm ²	suitable	80 m/min	P
Steel < 1100 N/mm ²	suitable	70 m/min	P
Steel < 1400 N/mm ²	suitable	65 m/min	P
TOOLOX 33	suitable	55 m/min	H
TOOLOX 44	suitable	50 m/min	H
INOX < 900 N/mm ²	suitable	45 m/min	M
INOX > 900 N/mm ²	suitable	40 m/min	M
Ti > 850 N/mm ²	suitable only under restricted conditions	30 m/min	S
Uni	suitable only under restricted conditions		
wet maximum	suitable		
wet minimum	Suitable		
dry	suitable only under restricted conditions		

