

**Garant**
**Solid carbide milling cutter HPC, TiAlN, Ø e8 DC: 12mm**

**Order data**

Order number	203026 12
GTIN	4045197857989
Item class	11X

**Description**
**Note:**

Successor product to No. 203025.

**Technical description**

Feed $f_z$ for side milling in INOX > 900 N/mm <sup>2</sup>	0.065 mm
Shank	DIN 6535 HB to h6
Cutting edge Ø D <sub>c</sub>	12 mm
Direction of infeed	horizontal, oblique and vertical
Shank Ø D <sub>s</sub>	12 mm
Corner chamfer width at 45°	0.5 mm
Overhang length L <sub>1</sub> incl. recess	73 mm
No. of teeth Z	4
Flute length L <sub>c</sub>	24 mm
Overall length L	125 mm
Recess Ø D <sub>1</sub>	11 mm
Tolerance nominal Ø	e8
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 <sup>2</sup>	suitable	120 m/min	P
Steel < 750 N/mm <sup>2</sup>	suitable	110 m/min	P
Steel < 900 N/mm <sup>2</sup>	suitable	100 m/min	P
Steel < 1100 N/mm <sup>2</sup>	suitable	90 m/min	P
Steel < 1400 N/mm <sup>2</sup>	suitable	80 m/min	P
TOOLOX 33	suitable	70 m/min	H
TOOLOX 44	suitable	60 m/min	H
INOX < 900 N/mm <sup>2</sup>	suitable	55 m/min	M
INOX > 900 N/mm <sup>2</sup>	suitable	45 m/min	M
Ti > 850 N/mm <sup>2</sup>	suitable only under restricted conditions	35 m/min	S
Uni	suitable only under restricted conditions		
wet maximum	suitable		
wet minimum	Suitable		
dry	suitable only under restricted conditions		

