

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

Order data

Order number	GG1294 20
GTIN	4045197907837
Item class	GGN

Description
Version:

Dimensions similar to **DIN 6527**. Improved coating for general-purpose applications in steel and cast iron.

Same as No. 202294.

Technical description

Cutting edge Ø D_c	20 mm
Tolerance nominal Ø	e8
Recess Ø D_1	19.7 mm
Feed f_z for slot milling in steel < 750 N/mm ²	0.1 mm
Shank Ø D_s	20 mm
Shank form	HB
Flute length L_c	38 mm
Corner chamfer width at 45°	0.5 mm
Direction of infeed	horizontal, oblique and vertical

Overall length L	104 mm
Feed f_z for side milling in steel < 750 N/mm ²	0.15 mm
Shank	DIN 6535 HB to h6
Overhang length L_1 incl. recess	54 mm
No. of teeth Z	3
Helix angle	45 degrees
Corner chamfer angle	45 degrees
Contents	5
Coating	AlCrN
Tool material	Solid carbide
Standard	DIN 6527
Type	N
Cutting width a_e for milling operation	0.5×D for side milling
Cutting width a_e for milling operation	Full slot cutting depth 1×D
Type of product	End / face mill

User data

	Suitability	V_c	ISO code
Aluminium (short chipping)	suitable only under restricted conditions	280 m/min	N
Alu > 10% Si	suitable only under restricted conditions	200 m/min	N
Steel < 500 N/mm ²	suitable	120 m/min	P
Steel < 750 N/mm ²	suitable	110 m/min	P
Steel < 900 N/mm ²	suitable	100 m/min	P
Steel < 1100 N/mm ²	suitable	70 m/min	P
Steel < 1400 N/mm ²	suitable only under restricted conditions	60 m/min	P
INOX < 900 N/mm ²	suitable	70 m/min	M

INOX > 900 N/mm ²	suitable only under restricted conditions	50 m/min	M
GG(G)	suitable	90 m/min	K
Uni	suitable		
wet maximum	suitable		
wet minimum	suitable		
dry	Suitable only under restricted conditions		
Air	suitable		

Accessories

Solid carbide milling cutter Ø e8 DC 20 mm

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