

Garant
PickPocket end milling head, HB730, Ø D h10: 19,7mm

Order data

Order number	210050 19,7
GTIN	4045197941169
Item class	21M

Description
Note:

Standard application values for $a_{p,max} \leq 0.5 \times D$.

Technical description

Feed f_z for side milling in steel $< 900 \text{ N/mm}^2$	0.13 mm
Feed f_z for slot milling in steel $< 900 \text{ N/mm}^2$	0.1 mm
Head length l	25 mm
Flute length L_2	15 mm
Cutter $\varnothing D$	19.7 mm
Arbor size	20 mm
Corner rounding r_v	0,5
Overall length L	47.2 mm
Number of cutting edges Z	3
Series	GARANT Master Steel
Series	TopCut
Grade	HB730
Tool material	Solid carbide

Standard	Manufacturer's standard
Type	N
Spacing of the cutters	unequal spacing
Helix angle	38 degrees
Helix angle characteristic	unequal spacing
Direction of infeed	horizontal, oblique and vertical
Cutting width a_e for milling operation	0.3×D for side milling mm
Cutting width a_e for milling operation	Full slot cutting depth 1×D mm
Machining strategy	HPC
Through-coolant	no
suitable arbor	GARANT TopCut
Type of product	Cutter insert for milling

User data

	Suitability	V_c	ISO code
Steel < 500 N/mm ²	suitable	210 m/min	P
Steel < 750 N/mm ²	suitable	170 m/min	P
Steel < 900 N/mm ²	suitable	150 m/min	P
Steel < 1100 N/mm ²	suitable	130 m/min	P
Steel < 1400 N/mm ²	suitable only under restricted conditions	110 m/min	P
Steel < 55 HRC	suitable only under restricted conditions	50 m/min	H
Steel < 60 HRC	suitable only under restricted conditions	40 m/min	H
INOX < 900 N/mm ²	suitable	80 m/min	M
INOX > 900 N/mm ²	suitable only under restricted conditions	50 m/min	M
Ti > 850 N/mm ²	suitable only under restricted conditions	80 m/min	S

GG(G)	suitable	160 m/min	K
Oil	suitable only under restricted conditions		
wet maximum	suitable		
wet minimum	suitable only under restricted conditions		
dry	suitable only under restricted conditions		
Air	suitable		