Garant

Solid carbide milling cutter with chip separators TPC, TiAlN, ⌀ f8 DC: 8mm

Order data

Order number	203079 8
GTIN	4045197953803
Item class	11X

Description

Version:
High-performance slot drill for machining materials up to 60 HRC, **specially designed for TPC applications**.
Strengthened core. With corner radii similar to torus cutters.
Chip breakers for controlled chip breaking.
Note:
h_{max}: The values stated in the table are maximum values.
$a_{e\,max}$ = 0.05×D for TPC machining.

Technical description

Helix angle	45 degrees
Flute length L_c	24 mm
Balance quality with shank	G 2.5 with HB
Cutting edge ⌀ D_C	8 mm
Direction of infeed	horizontal and oblique
Overhang length L_1 incl. recess	30 mm
Overall length L	68 mm
Shank ⌀ D_s	8 mm
Recess ⌀ D_1	7.8 mm
Shank	DIN 6535 HB to h6
Tolerance nominal ⌀	f8

Average chip thickness h_{max} for TPC milling in steel < 60 HRC	0.022 mm
No. of teeth Z	5
Corner rounding r_v	0.2 mm
Coating	TiAlN
Tool material	Solid carbide
Standard	Manufacturer's standard
Type	H
Helix angle characteristic	unequal spacing
Spacing of the cutters	unequal spacing
Cutting width a_e for milling operation	0.05×D
Through-coolant	no
Machining strategy	TPC
Colour ring	red
Type of product	End / face mill

User data

	Suitability	V_c	ISO code
Steel < 1400 N/mm²	suitable	150 m/min	P
Steel < 50 HRC	suitable	140 m/min	H
Steel < 55 HRC	suitable	125 m/min	H
Steel < 60 HRC	suitable	110 m/min	H
dry	Suitable only under restricted conditions		
Air	suitable		