

Garant

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



Order data

Order number	203094 8
GTIN	4045197954008
Item class	11X

Description

Version:

High-performance end mill for general-purpose applications, **specially designed for TPC applications.**

Strengthened core.

Optimised bending strength due to the use of ultra-fine grain substrates.

Offset chip breakers for controlled chip breaking.

Note:

$a_{e\max} = 0.03 \times D$ for TPC machining.

h_{\max} : The values stated in the table are maximum values. For finishing operations we recommend items No. 204016, 204018 and 204019.

Successor product to No. 203091.

Technical description

Balance quality with shank	G 2.5 with HB
Shank Ø D_s	8 mm
Average chip thickness h_{\max} for TPC milling in Toolox 44 HRC	0.03 mm
Shank	DIN 6535 HB to h6
Overall length L	81 mm
Direction of infeed	horizontal and oblique
Cutting edge Ø D_c	8 mm
No. of teeth Z	5

Corner chamfer width at 45°	0.16 mm
Flute length L_c	40 mm
Helix angle	40 degrees
Tolerance nominal \varnothing	f8
Corner chamfer angle	45 degrees
Number of chip separators	3
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	0.03×D
Through-coolant	no
Machining strategy	TPC
Colour ring	green
Type of product	End / face mill

User data

	Suitability	V_c	ISO code
Steel < 500 N/mm ²	suitable	350 m/min	P
Steel < 750 N/mm ²	suitable	310 m/min	P
Steel < 900 N/mm ²	suitable	270 m/min	P
Steel < 1100 N/mm ²	suitable	200 m/min	P
Steel < 1400 N/mm ²	suitable	120 m/min	P
TOOLOX 33	suitable	50 m/min	H
TOOLOX 44	suitable	30 m/min	H
HARDOX 500 < 1600 N/mm ²	suitable	20 m/min	H

INOX < 900 N/mm ²	suitable	190 m/min	M
INOX > 900 N/mm ²	suitable only under restricted conditions	120 m/min	M
Uni	suitable		
wet maximum	Suitable		
dry	Suitable only under restricted conditions		
Air	suitable		