

Garant

Solid carbide milling cutter with more chip separators TPC, TiAlN, Ø f8 DC: 14mm



Order data

Order number	203106 14
GTIN	4045197954060
Item class	11X

Description

Version:

High-performance milling cutter with **irregular cutter spacing** and **irregular helical pitch**. Optimised bending strength due to the use of ultra-fine grain substrates.

Chip separator for controlled chip breaking.

Note:

h_{max} : The values stated in the table are maximum values.

$a_{e max} = 0.07 \times D$ for TPC machining.

Tolerance nominal Ø: f8

No. of teeth Z: 7

Helix angle: 40 °

Direction of infeed: horizontal and oblique

Shank: DIN 6535 HB to h6

Balance quality with shank: G 2.5 with HB

No. of teeth Z: 7

Flute length L_c : 42 mm

Overhang length L_1 incl. recess: 50 mm

Recess Ø D_1 : 13.8 mm

Overall length L: 99 mm

Shank Ø D_s : 14 mm

Technical description

Helix angle	40 °
Corner chamfer width at 45°	0.28 mm
Tolerance nominal Ø	f8

Cutting edge $\varnothing D_c$	14 mm
Direction of infeed	horizontal and oblique
Average chip thickness h_{max} for TPC milling in INOX < 900 N/mm ²	0.069 mm
Recess $\varnothing D_1$	13.8 mm
Overhang length L_1 incl. recess	50 mm
No. of teeth Z	7
Shank $\varnothing D_s$	14 mm
Flute length L_c	42 mm
Overall length L	99 mm
Balance quality with shank	G 2.5 with HB
Shank	DIN 6535 HB to h6
Corner chamfer angle	45 °
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	0.07×D
Through-coolant	no
Machining strategy	TPC
Colour ring	blue
Type of product	End / face mill

User data

	Suitability	V_c	ISO code
Steel < 500 N/mm ²	suitable	380 m/min	P
Steel < 750 N/mm ²	suitable	340 m/min	P

Steel < 900 N/mm ²	suitable	300 m/min	P
Steel < 1100 N/mm ²	suitable	230 m/min	P
INOX < 900 N/mm ²	suitable	240 m/min	M
INOX > 900 N/mm ²	suitable	170 m/min	M
wet maximum	Suitable		
wet minimum	Suitable only under restricted conditions		
Air	suitable		