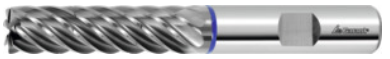
Garant

Solid carbide milling cutter with more chip separators TPC, TiAlN, ∅ f8 DC: 12mm



Order data

Order number	203107 12
GTIN	4045197954138
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.
$a_{e\,max}$ = 0.05×D for TPC machining.
Tolerance nominal ∅: 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: 48 mm
Overall length L: 100 mm
Shank ∅ D_s: 12 mm
Corner chamfer width at 45°: 0.24 mm
Average chip thickness h_{max} for TPC milling in INOX < 900 N/mm^2: 0.054 mm

Technical description

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Tolerance nominal ∅	f8
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Corner chamfer width at 45°	0.24 mm
Direction of infeed	horizontal and oblique
Shank	DIN 6535 HB to h6
Helix angle	40 °
Overall length L	100 mm
Shank ∅ D_s	12 mm
Balance quality with shank	G 2.5 with HB
Cutting edge ∅ D_C	12 mm
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	0.05×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/mm²	suitable	320 m/min	P
Steel < 750 N/mm²	suitable	290 m/min	P
Steel < 900 N/mm²	suitable	260 m/min	P
Steel < 1100 N/mm²	suitable	200 m/min	P

INOX < 900 N/mm²	suitable	220 m/min	M
INOX > 900 N/mm²	suitable	160 m/min	M
wet maximum	Suitable		
wet minimum	Suitable only under restricted conditions		
Air	suitable		