

**Garant**
**GARANT Master Titan solid carbide finishing cutter HPC, uncoated, Ø e8 DC: 20mm**

**Order data**

Order number	203634 20
GTIN	4045197992116
Item class	11Z

**Description**
**Version:**

For **finishing operations**.

Special geometry for optimum chip evacuation.

Unequal spacing gives high **intrinsic stability and smooth cutting action**.

For **profile milling as a finishing operation** in **titanium and titanium alloys**.

**Advantage:**

Suitable for medical technology and approved for foodstuffs.

**Technical description**

Tolerance nominal Ø	e8
Feed $f_z$ for side milling in titanium > 850 N/mm <sup>2</sup>	0.034 mm
Overall length L	140 mm
Helix angle	40 degrees
Shank	DIN 6535 HA to h6
Shank Ø $D_s$	20 mm
Cutting edge Ø $D_c$	20 mm
No. of teeth Z	7
Direction of infeed	horizontal
Flute length $L_c$	80 mm
Corner rounding $r_v$	0.1 mm

Series	Master Titan
Coating	uncoated
Tool material	Solid carbide
Standard	Manufacturer's standard
Type	N
Helix angle characteristic	unequal spacing
Cutting width $a_e$ for milling operation	$0.05 \times D$ for side milling
Through-coolant	no
Machining strategy	HPC
Colour ring	pink
Type of product	End / face mill

## User data

	Suitability	$V_c$	ISO code
Alu plastics	suitable only under restricted conditions	130 m/min	N
Aluminium (short chipping)	suitable only under restricted conditions	100 m/min	N
Alu > 10% Si	suitable only under restricted conditions	85 m/min	N
Ti > 850 N/mm <sup>2</sup>	suitable	60 m/min	S
wet maximum	suitable		

## Services

Shank grinding Type HB	129100 HB
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