

GARANT Master Alu solid carbide finishing cutter HPC, uncoated, Ø h6 DC: 20mm



Order data

Order number	203215 20
GTIN	4067263100461
Item class	11X

Description

Version:

For fine finishing operations. Cutter geometry optimised for low infeeds and excellent surfaces. Unequal spacing gives high intrinsic stability and smooth cutting action.

Application:

For profile milling as a finishing operation.

Note:

Optimal production results in conjunction with the GARANT HiRunER precision ER collet chuck, GARANT Master Chuck hydraulic chuck and heavy-duty chuck.

Technical description

Flute length L_c	105 mm
Overhang length L_1 incl. recess	113 mm
Overall length L	175 mm
Shank	DIN 6535 HA to h6
Corner chamfer angle	90 degrees
No. of teeth Z	7
Direction of infeed	horizontal
Cutting edge $\varnothing D_c$	20 mm
Tolerance nominal \varnothing	h6
Shank $\varnothing D_s$	20 mm

Balance quality with shank	G 2.5 with HA
Recess $\varnothing D_1$	19.5 mm
Helix angle	40 degrees
Feed f_z for side milling in short-chipping aluminium	0.035 mm
Series	Master Alu
Coating	uncoated
Tool material	Solid carbide
Standard	Works standard
Type	W
Helix angle characteristic	unequal spacing
Spacing of the cutters	unequal spacing
Milling application	Mono milling tools high-precision 90°
Cutting width a_e for milling operation	0.015×D for side milling
Through-coolant	no
Machining strategy	HPC
Colour ring	yellow
Type of product	End / face mill

User data

	Suitability	V_c	ISO code
Alu plastics	suitable	380 m/min	N
Aluminium (short chipping)	suitable	360 m/min	N
Alu > 10% Si	suitable only under restricted conditions	320 m/min	N
PMMA acrylic	suitable	260 m/min	N
PE-HD	suitable	220 m/min	N
PA 66	suitable	250 m/min	N
PEEK	suitable	220 m/min	N

PF 31	suitable	200 m/min	N
Cu	suitable only under restricted conditions	160 m/min	N
CuZn	suitable	220 m/min	N
wet maximum	suitable		
wet minimum	suitable		
Air	suitable		

Services

Shank grinding Type HB	129100 HB
------------------------	-----------