

Garant

Solid carbide milling cutter TPC, uncoated, Ø h6 DC: 20mm



Order data

Order number	202283 20
GTIN	4045197977274
Item class	11X

Description

Version:

Eccentric relief ground, additionally **polish ground** in the flutes for **outstanding chip evacuation** in long-chipping aluminium workpieces.

With double chip-breaker for exemplary chip formation.

Note:

$a_{e\ max} = 0.1 \times D$ for TPC machining.

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

Technical description

Shank Ø D_s	20 mm
Shank form	HB
Helix angle	45 degrees
Average chip thickness h_{max} for TPC milling in short-chipping aluminium	0.108 mm
Direction of infeed	horizontal, oblique and vertical
Balance quality with shank	G 2.5 with HB
No. of teeth Z	3
Flute length L_c	102 mm
Overhang length L_1 incl. recess	120 mm
Recess Ø D_1	19 mm
Shank	DIN 6535 HB to h6

Overall length L	174 mm
Tolerance nominal \varnothing	h6
Corner chamfer width at 45°	0.2 mm
Cutting edge $\varnothing D_c$	20 mm
Corner chamfer angle	45 degrees
Coating	uncoated
Tool material	Solid carbide
Standard	Manufacturer's standard
Type	W
Helix angle characteristic	unequal spacing
Cutting width a_e for milling operation	0.1×D
Through-coolant	no
Machining strategy	TPC
Colour ring	yellow
Type of product	End / face mill

User data

	Suitability	V_c	ISO code
Aluminium	Suitable	130 m/min	N
Aluminium (short chipping)	suitable	100 m/min	N
Alu > 10% Si	suitable	85 m/min	N
PMMA acrylic	suitable	125 m/min	N
PE-HD	Suitable	90 m/min	N
PA 66	Suitable	100 m/min	N
PEEK	suitable	80 m/min	N
PF 31	Suitable	70 m/min	N
Honeycomb sandwich	suitable only under restricted conditions	100 m/min	N

Cu	Suitable	70 m/min	N
CuZn	Suitable	90 m/min	N
wet maximum	suitable		
wet minimum	suitable		
dry	suitable only under restricted conditions		
Air	suitable only under restricted conditions		