

Garant
GARANT Master Alu solid carbide milling cutter, HPC HPC, DLC, Ø h6 DC: 8mm

Order data

Order number	203204 8
GTIN	4062406119935
Item class	11X

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.

Note:

Order the **uncoated version** using **No. 203208**.

Technical description

Overall length L	75 mm
No. of teeth Z	5
Feed f_z for side milling in short-chipping aluminium	0.05 mm
Helix angle	38 degrees
Recess $\varnothing D_1$	7.8 mm
Shank	DIN 6535 HA to h6
Balance quality with shank	G 2.5 with HA
Shank $\varnothing D_s$	8 mm
Cutting edge $\varnothing D_c$	8 mm
Flute length L_c	32 mm
Overhang length L_1 incl. recess	40 mm

Tolerance nominal \varnothing	h6
Direction of infeed	horizontal
Corner chamfer angle	90 degrees
Series	Master Alu
Coating	DLC
Tool material	Solid carbide
Standard	Manufacturer's standard
Type	W
Spacing of the cutters	unequal spacing
Cutting width a_e for milling operation	$0.1 \times D$ 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
Aluminium	Suitable	500 m/min	N
Aluminium (short chipping)	suitable	450 m/min	N
Alu > 10% Si	suitable	400 m/min	N
PMMA acrylic	Suitable	180 m/min	N
PE-HD	Suitable	140 m/min	N
PA 66	Suitable	180 m/min	N
PEEK	Suitable	130 m/min	N
PF 31	Suitable	110 m/min	N
PVDF GF20	Suitable	160 m/min	N
POM GF25	Suitable	140 m/min	N
PA 66 GF30	Suitable	140 m/min	N

PEEK GF30	Suitable	120 m/min	N
PTFE CF25	Suitable	140 m/min	N
Honeycomb sandwich	suitable only under restricted conditions	260 m/min	N
Cu	Suitable	140 m/min	N
CuZn	suitable	120 m/min	N
wet maximum	suitable		
wet minimum	suitable only under restricted conditions		
dry	suitable		
Air	suitable		

Services

Shank grinding Type HB

129100 HB