

**Garant**
**Solid carbide end mill HPC, ZOx, Ø f8 DC: 20mm**

**Order data**

Order number	202549 20
GTIN	4045197454300
Item class	11X

**Description**
**Version:**

Sturdy roughing slot drills **without** knuckle profile.

With strong core, **special chip breaker recesses** and **large polished flutes**.

**Application:**

For roughing milling with high demands on the component surface.

**Technical description**

Feed $f_z$ for slot milling in short-chipping aluminium	0.16 mm
Recess $\varnothing D_1$	19 mm
Cutting edge $\varnothing D_c$	20 mm
Feed $f_z$ for side milling in short-chipping aluminium	0.18 mm
Overhang length $L_1$ incl. recess	74 mm
Shank form	HB
No. of teeth Z	4
Corner chamfer width at 45°	0.2 mm
Shank $\varnothing D_s$	20 mm
Overall length L	126 mm
Flute length $L_c$	60 mm
Direction of infeed	horizontal, oblique and vertical
Shank	DIN 6535 HB to h6

Tolerance nominal $\varnothing$	f8
Balance quality with shank	G 2.5 with HB
Helix angle	45 degrees
Corner chamfer angle	45 degrees
Coating	ZOX
Tool material	Solid carbide
Standard	Manufacturer's standard
Type	W
Helix angle characteristic	unequal spacing
Spacing of the cutters	unequal spacing
Cutting width $a_e$ for milling operation	0.3×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 only under restricted conditions	500 m/min	N
Aluminium (short chipping)	suitable	480 m/min	N
Alu > 10% Si	suitable	240 m/min	N
Hybrids	suitable only under restricted conditions	m/min	N
Honeycomb sandwich	suitable only under restricted conditions	m/min	N
CuZn	Suitable	240 m/min	N
wet maximum	suitable		
wet minimum	suitable		

dry	suitable only under restricted conditions
Air	suitable only under restricted conditions