

Garant
Solid carbide high precision milling cutter, TiAlN, Ø f8 DC: 20mm

Order data

Order number	203540 20
GTIN	4045197509932
Item class	11X

Description
Version:

High stability and **extremely smooth cutting action** due to at least 6 teeth. **Eccentric relief ground.**

Extremely **high taper accuracy with tolerances in the µm range**, for **precise 90° angles** and plane-parallel surfaces in profile milling.

For the most demanding angular accuracy.

Cutter corner chamfer undefined due to eccentric relief grinding.

With maximum 0.014 mm tapering.

Application:

For peripheral milling as a **finishing operation.**

Technical description

Feed f_z for side milling in steel $< 900 \text{ N/mm}^2$	0.1 mm
No. of teeth Z	8
Cutting edge $\varnothing D_c$	20 mm
Shank $\varnothing D_s$	20 mm
Overall length L	160 mm
Flute length L_c	100 mm
Direction of infeed	horizontal
Shank	DIN 6535 HA to h6
Tolerance nominal \varnothing	f8
Balance quality with shank	G 2.5 with HA

Helix angle	45 degrees
Corner chamfer angle	90 degrees
Coating	TiAlN
Tool material	Solid carbide
Standard	Manufacturer's standard
Type	N
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	0.05×D for side milling
Through-coolant	no
Colour ring	green
Type of product	End / face mill

User data

	Suitability	V_c	ISO code
Steel < 500 N/mm ²	suitable	200 m/min	P
Steel < 750 N/mm ²	suitable	160 m/min	P
Steel < 900 N/mm ²	suitable	140 m/min	P
Steel < 1100 N/mm ²	suitable	115 m/min	P
Steel < 1400 N/mm ²	suitable	100 m/min	P
Steel < 55 HRC	suitable only under restricted conditions	40 m/min	H
INOX < 900 N/mm ²	suitable	80 m/min	M
INOX > 900 N/mm ²	suitable only under restricted conditions	65 m/min	M
GG(G)	suitable only under restricted conditions	175 m/min	K
Uni	suitable		
wet maximum	suitable		

wet minimum	suitable only under restricted conditions
dry	suitable only under restricted conditions
Air	suitable only under restricted conditions
Services	
Shank grinding Type HB	129100 HB