

## Garant

### Solid carbide Woodruff keyseating cutter, TiAlN, Ø DC × LC h11 × e8: 25,5X5mm



#### Order data

Order number	208024 25,5X5
GTIN	4062406397111
Item class	11X

#### Description

##### Version:

**With new high-performance coating** for very long tool life. Peripheral cutting, alternate set teeth (staggered). The sides of the teeth are ground to give clearance

##### Note:

Suitable for milling Woodruff keyways to DIN 6888.

$f_z$  for  $a_p = 0.1 \times D$ .

**Successor product to No. 208025.**

#### Technical description

Feed $f_z$ in steel $< 900 \text{ N/mm}^2$	0.04 mm
for Woodruff keyways to DIN 6888	5.0×10.0 mm
Recess Ø $D_1$	7.5 mm
Cutting edge Ø $D_c$	25.5 mm
Type	N
Shank Ø $D_s$	10 mm
No. of teeth Z	10
Overall length L	63 mm
Flute length $L_c$	5 mm
Coating	TiAlN

Tool material	Solid carbide
Standard	DIN 850 D/F
Milling profile	staggered teeth
Tolerance nominal $\varnothing$	e8
Direction of infeed	horizontal
Shank	DIN 6535 HB to h6
Through-coolant	no
Shank tolerance	h6
Corner chamfer angle	90 degrees
Colour ring	green
Type of product	Slot milling cutter

## User data

	Suitability	$V_c$	ISO code
Steel < 500 N/mm <sup>2</sup>	suitable	70 m/min	P
Steel < 750 N/mm <sup>2</sup>	suitable	67 m/min	P
Steel < 900 N/mm <sup>2</sup>	suitable	65 m/min	P
Steel < 1100 N/mm <sup>2</sup>	suitable	63 m/min	P
Steel < 1400 N/mm <sup>2</sup>	suitable only under restricted conditions	60 m/min	P
INOX < 900 N/mm <sup>2</sup>	suitable	40 m/min	M
Uni	suitable		
wet maximum	suitable		