

Garant
**Solid carbide Woodruff keyseating cutter, TiAlN, \varnothing DC \times LC h11 \times e8:
13,5X3mm**

Order data

| | |
|--------------|---------------|
| Order number | 208024 13,5X3 |
| GTIN | 4062406397043 |
| 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

| | |
|---|---------------------|
| No. of teeth Z | 8 |
| Overall length L | 56 mm |
| Cutting edge \varnothing D _c | 13.5 mm |
| Recess \varnothing D ₁ | 4.6 mm |
| Type | N |
| for Woodruff keyways to DIN 6888 | 3.0 \times 5.0 mm |
| Shank \varnothing D _s | 10 mm |
| Feed f_z in steel < 900 N/mm ² | 0.03 mm |
| Flute length L _c | 3 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 ² | suitable | 70 m/min | P |
| Steel < 750 N/mm ² | suitable | 67 m/min | P |
| Steel < 900 N/mm ² | suitable | 65 m/min | P |
| Steel < 1100 N/mm ² | suitable | 63 m/min | P |
| Steel < 1400 N/mm ² | suitable only under restricted conditions | 60 m/min | P |
| INOX < 900 N/mm ² | suitable | 40 m/min | M |
| Uni | suitable | | |
| wet maximum | suitable | | |