

Garant
**Solid carbide Woodruff keyseating cutter, TiAlN, \varnothing DC \times LC h11 \times e8:
13,5X4mm**

Order data

Order number	208024 13,5X4
GTIN	4062406397050
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

Type	N
Overall length L	56 mm
No. of teeth Z	8
Recess \varnothing D ₁	4.6 mm
for Woodruff keyways to DIN 6888	4.0 \times 5.0 mm
Feed f_z in steel < 900 N/mm ²	0.03 mm
Shank \varnothing D _s	10 mm
Cutting edge \varnothing D _c	13.5 mm
Flute length L _c	4 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		