

**Garant**
**Solid carbide dovetail milling cutter Form D 45°, TiAlN, Ø js14 DC: 28mm**

**Order data**

Order number	208029 28
GTIN	4062406397739
Item class	11X

**Description**
**Version:**

**With new high-performance coating** for very long tool life.

Angular tolerance  $\pm 8$  arc minutes.

**Note:**

For milling dovetails in tool making and machine building.

**Successor product to No. 208036.**

Feed at 50 %  $f_z$  until full engagement.

**Technical description**

Shape	D
Overall length L	80 mm
Cutting edge $\varnothing D_c$	28 mm
No. of teeth Z	10
Feed $f_z$ in steel $< 900 \text{ N/mm}^2$	0.045 mm
Flute length $L_c$	7.5 mm
Shank $\varnothing D_s$	16 mm
Recess $\varnothing D_1$	14 mm
Coating	TiAlN
Tool material	Solid carbide

Standard	DIN 1833
Tolerance nominal $\varnothing$	js14
Type	N
Direction of infeed	horizontal
Shank	DIN 6535 HB to h6
Through-coolant	no
Shank tolerance	h6
Corner chamfer angle	45 degrees
Colour ring	green
Type of product	Dovetail milling cutter

## User data

	Suitability	$V_c$	ISO code
Steel < 500 N/mm <sup>2</sup>	suitable	105 m/min	P
Steel < 750 N/mm <sup>2</sup>	suitable	90 m/min	P
Steel < 900 N/mm <sup>2</sup>	suitable	90 m/min	P
Steel < 1100 N/mm <sup>2</sup>	suitable	80 m/min	P
Steel < 1400 N/mm <sup>2</sup>	suitable only under restricted conditions	60 m/min	P
Uni	suitable		
wet maximum	suitable		