

**Garant**
**Solid carbide dovetail milling cutter Form D 45°, TiAlN, Ø js14 DC: 22mm**

**Order data**

Order number	208029 22
GTIN	4062406397715
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
Feed $f_z$ in steel < 900 N/mm <sup>2</sup>	0.043 mm
Shank Ø $D_s$	12 mm
Overall length L	67 mm
No. of teeth Z	8
Flute length $L_c$	6 mm
Recess Ø $D_1$	10.2 mm
Cutting edge Ø $D_c$	22 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		