

Garant
Solid carbide dovetail milling cutter Form D 45°, TiAlN, Ø js14 DC: 25mm

Order data

Order number	208029 25
GTIN	4062406397722
Item class	11X

Description
Version:

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

Angular tolerance ± 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

Flute length L_c	6.3 mm
Overall length L	67 mm
No. of teeth Z	8
Feed f_z in steel $< 900 \text{ N/mm}^2$	0.045 mm
Shank $\varnothing D_s$	12 mm
Recess $\varnothing D_1$	11 mm
Shape	D
Cutting edge $\varnothing D_c$	25 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 ²	suitable	105 m/min	P
Steel < 750 N/mm ²	suitable	90 m/min	P
Steel < 900 N/mm ²	suitable	90 m/min	P
Steel < 1100 N/mm ²	suitable	80 m/min	P
Steel < 1400 N/mm ²	suitable only under restricted conditions	60 m/min	P
Uni	suitable		
wet maximum	suitable		