

**Garant**
**Solid carbide dovetail milling cutter Form C 60°, TiAlN, Ø js14 DC: 25mm**

**Order data**

Order number	208030 25
GTIN	4062406397807
Item class	11X

**Description**
**Version:**

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

Angular tolerance  $\pm 8$  arc minutes.

**Note:**

**Successor product to No. 208037.**

For milling dovetails in tool making and machine building.

Feed at 50 %  $f_z$  until full engagement.

**Technical description**

Cutting edge $\varnothing D_c$	25 mm
Shape	C
Overall length L	67 mm
No. of teeth Z	8
Shank $\varnothing D_s$	12 mm
Feed $f_z$ in steel $< 900 \text{ N/mm}^2$	0.045 mm
Flute length $L_c$	10 mm
Recess $\varnothing D_1$	9 mm
Coating	TiAlN
Tool material	Solid carbide

Standard	DIN 1833
Type	N
Tolerance nominal $\varnothing$	js14
Direction of infeed	horizontal
Shank	DIN 6535 HB to h6
Through-coolant	no
Shank tolerance	h6
Corner chamfer angle	60 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		