

Garant
Solid carbide milling cutter HPC, TiAlN, Ø DC: 25mm

Order data

Order number	203009 25
GTIN	4045197588708
Item class	11X

Description
Version:

Specially for **machining stainless steels such as duplex steels at high rates of metal removal.**
 Cutting edge chamfer: Size 4 = 0.07mm; size 5 – 8 = 0.12 mm; size 10 – 18 = 0.2 mm; ≥ size 20 = 0.3 mm

Technical description

Overhang length L_1 incl. recess	60 mm
No. of teeth Z	6
Recess $\varnothing D_1$	24.5 mm
Cutting edge $\varnothing D_c$	25 mm
Corner chamfer width at 45°	0.3 mm
Feed f_z for slot milling in stainless steel > 900 N/mm ²	0.07 mm
Feed f_z for side milling in INOX > 900 N/mm ²	0.1 mm
Shank $\varnothing D_s$	25 mm
Overall length L	125 mm
Flute length L_c	45 mm
Direction of infeed	horizontal, oblique and vertical
Shank	DIN 6535 HB to h6
Tolerance nominal \varnothing	h10

Helix angle	38 degrees
Corner chamfer angle	45 degrees
Coating	TiAlN
Tool material	Solid carbide
Standard	DIN 6527
Type	N
Helix angle characteristic	unequal spacing
Spacing of the cutters	unequal spacing
Cutting width a_e for milling operation	0.3×D for side milling
Cutting width a_e for milling operation	Full slot cutting depth 1×D
Through-coolant	no
Machining strategy	HPC
Colour ring	blue
Type of product	End / face mill

User data

	Suitability	V_c	ISO code
INOX < 900 N/mm ²	suitable	110 m/min	M
INOX > 900 N/mm ²	suitable	90 m/min	M
wet maximum	suitable		
wet minimum	suitable		
dry	Suitable only under restricted conditions		
Air	suitable		