

Garant
Woodruff keyseating cutter, uncoated, \varnothing DC \times LC h11 \times e8: 22,5X4mm


Order data

Order number	194010 22,5X4
GTIN	4045197109279
Item class	11W

Description

Version:

Peripheral cutting, alternate set teeth (staggered).

The sides of the teeth are ground to give clearance and thus cannot jam in the component.

Special surface treatment.

Note:

For milling Woodruff keyways to DIN 6888 or for milling small slots.

Technical description

Feed f_z for slot milling in steel $< 750 \text{ N/mm}^2$	0.08 mm
Cutting edge $\varnothing D_c$	22.5 mm
for Woodruff keyways to DIN 6888	4.0 \times 9.0 mm
No. of teeth Z	10
Shank $\varnothing D_s$	10 mm
Overall length L	63 mm
Flute length L_c	4 mm
Coating	uncoated
Tool material	HSS Co 5
Standard	DIN 850 D/F

Milling profile	staggered teeth
Tolerance nominal \varnothing	e8
Direction of infeed	horizontal
Shank	DIN 1835 B to h6
Through-coolant	no
Shank tolerance	h6
Corner chamfer angle	90 degrees
Colour ring	without
Type of product	Slot milling cutter

User data

	Suitability	V_c	ISO code
Alu plastics	suitable only under restricted conditions	250 m/min	N
Aluminium (short chipping)	suitable	70 m/min	N
Steel < 500 N/mm ²	suitable	35 m/min	P
Steel < 750 N/mm ²	suitable	28 m/min	P
GG(G)	suitable only under restricted conditions	22 m/min	K
CuZn	suitable only under restricted conditions	35 m/min	N
Uni	suitable		
wet maximum	suitable		