

## Garant

### Solid carbide milling cutter HPC, ZOx, Ø f8 DC: 25mm



#### Order data

Order number	202248 25
GTIN	4045197454508
Item class	11X

#### Description

##### Version:

Sturdy roughing end mill **without** knuckle profile.

With strong core, **special chip breaker recesses** and **large polished flutes**.

##### Application:

For roughing milling with high demands on the component surface.

##### Note:

**NEW GENERATION AVAILABLE!**

**Recommended successor product is No. 202004.**

#### Technical description

Feed $f_z$ for slot milling in short-chipping aluminium	0.14 mm
Recess $\varnothing D_1$	24 mm
Shank form	HB
Cutting edge $\varnothing D_c$	25 mm
Feed $f_z$ for side milling in short-chipping aluminium	0.18 mm
Corner chamfer width at 45°	0.3 mm
No. of teeth Z	3
Overhang length $L_1$ incl. recess	62 mm
Shank $\varnothing D_s$	25 mm
Overall length L	121 mm
Flute length $L_c$	52 mm

Direction of infeed	horizontal, oblique and vertical
Shank	DIN 6535 HB to h6
Tolerance nominal $\varnothing$	f8
Balance quality with shank	G 2.5 with HB
Helix angle	45 degrees
Corner chamfer angle	45 degrees
Coating	ZOX
Tool material	Solid carbide
Standard	Manufacturer's standard
Type	W
Helix angle characteristic	unequal spacing
Spacing of the cutters	unequal spacing
Cutting width $a_e$ for milling operation	0.5×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	yellow
Type of product	End / face mill

## User data

	Suitability	$V_c$	ISO code
Aluminium	suitable only under restricted conditions	500 m/min	N
Aluminium (short chipping)	suitable	480 m/min	N
Alu > 10% Si	suitable	240 m/min	N
CuZn	suitable	240 m/min	N
wet maximum	suitable		
wet minimum	suitable only under restricted conditions		

dry	suitable only under restricted conditions
Air	suitable only under restricted conditions