

**Garant**
**Solid carbide micro Woodruff keyseating cutter, AlTiN, Ø DC × LC: 7,8X1,5mm**


## Order data

Order number	208033 7,8X1,5
GTIN	4062406774707
Item class	11Z

## Description

### Version:

Particularly suitable for slot milling and circular milling in holes. With optimised coating for universal application in virtually all materials.

**Tolerance, nominal diameter  $D_c = \pm 0.04$  mm.**

**Tolerance, cutter length  $L_c = \pm 0.02$  mm.** Minimum hole diameter is 8 mm.

### Note:

$ae_{max} = 0.1 \times D$ .

Always use climb milling. Engage loop of 180° to achieve the full depth of cut. Make sure the depth of the slot is linear.

## Technical description

Cutting edge Ø $D_c$	7.8 mm
Shank Ø $D_s$	8 mm
Overall length L	68 mm
No. of teeth Z	3
Type	N
Recess Ø $D_1$	5 mm
Feed $f_z$ for slot milling in steel < 900 N/mm <sup>2</sup>	0.03 mm
Flute length $L_c$	1.5 mm
Overhang $L_1$	25 mm
Coating	AlTiN

Tool material	Solid carbide
Standard	Manufacturer's standard
Tolerance nominal $\varnothing$	$\pm 0.04$
Direction of infeed	horizontal
Cutting width $a_e$ for milling operation	Full slot cutting depth $1 \times D$
Shank	DIN 6535 HA to h6
Through-coolant	no
Shank tolerance	h6
Corner chamfer angle	90 degrees
Colour ring	green
Type of product	Slot milling cutter

## User data

	Suitability	$V_c$	ISO code
Aluminium (short chipping)	suitable only under restricted conditions	300 m/min	N
Steel < 500 N/mm <sup>2</sup>	suitable	220 m/min	P
Steel < 750 N/mm <sup>2</sup>	suitable	190 m/min	P
Steel < 900 N/mm <sup>2</sup>	suitable	160 m/min	P
Steel < 1100 N/mm <sup>2</sup>	suitable	150 m/min	P
Steel < 1400 N/mm <sup>2</sup>	suitable only under restricted conditions	100 m/min	P
INOX < 900 N/mm <sup>2</sup>	suitable only under restricted conditions	100 m/min	M
GGG	suitable	180 m/min	K
Uni	suitable		
wet maximum	suitable		