

Garant
Solid carbide micro Woodruff keyseating cutter, AlTiN, Ø DC × LC: 7,8X0,9mm


Order data

Order number	208033 7,8X0,9
GTIN	4062406774684
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

Feed f_z for slot milling in steel < 900 N/mm ²	0.025 mm
Flute length L_c	0.9 mm
Type	N
Cutting edge Ø D_c	7.8 mm
Recess Ø D_1	5 mm
Overall length L	68 mm
Shank Ø D_s	8 mm
No. of teeth Z	3
Overhang L_1	25 mm
Coating	AlTiN

Tool material	Solid carbide
Standard	Manufacturer's standard
Tolerance nominal \varnothing	± 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 ²	suitable	220 m/min	P
Steel < 750 N/mm ²	suitable	190 m/min	P
Steel < 900 N/mm ²	suitable	160 m/min	P
Steel < 1100 N/mm ²	suitable	150 m/min	P
Steel < 1400 N/mm ²	suitable only under restricted conditions	100 m/min	P
INOX < 900 N/mm ²	suitable only under restricted conditions	100 m/min	M
GGG	suitable	180 m/min	K
Uni	suitable		
wet maximum	suitable		