

**Garant**
**Solid carbide milling cutter, TiAlN, Ø e8 DC: 25mm**

**Order data**

Order number	202720 25
GTIN	4045197117984
Item class	11X

**Description**
**Version:**

Double relief ground side clearance angle.

**Technical description**

No. of teeth Z	4
Shank form	HB
Feed $f_z$ for side milling in steel < 900 N/mm <sup>2</sup>	0.12 mm
Corner chamfer width at 45°	0.25 mm
Overhang length $L_1$ incl. recess	60 mm
Recess Ø $D_1$	24.5 mm
Cutting edge Ø $D_c$	25 mm
Feed $f_z$ for slot milling in steel < 900 N/mm <sup>2</sup>	0.1 mm
Shank Ø $D_s$	25 mm
Overall length L	125 mm
Flute length $L_c$	50 mm
Direction of infeed	horizontal, oblique and vertical
Shank	DIN 6535 HB to h6
Tolerance nominal Ø	e8
Helix angle	30 degrees

Corner chamfer angle	45 degrees
Coating	TiAlN
Tool material	Solid carbide
Standard	Manufacturer's standard
Type	H
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
Colour ring	without
Type of product	End / face mill

## User data

	Suitability	$V_c$	ISO code
Aluminium (short chipping)	suitable only under restricted conditions	280 m/min	N
Steel < 900 N/mm <sup>2</sup>	suitable	100 m/min	P
Steel < 1100 N/mm <sup>2</sup>	suitable	70 m/min	P
Steel < 1400 N/mm <sup>2</sup>	suitable	60 m/min	P
Steel < 55 HRC	suitable	35 m/min	H
INOX < 900 N/mm <sup>2</sup>	suitable	80 m/min	M
INOX > 900 N/mm <sup>2</sup>	suitable only under restricted conditions	60 m/min	M
GG(G)	suitable	90 m/min	K
Uni	suitable		
wet maximum	Suitable		
wet minimum	Suitable only under restricted conditions		
dry	suitable		
Air	Suitable		

