

Garant
End milling head, 45° chamfer with IC, HB730, Ø D h10: 25mm

Order data

Order number	210100 25
GTIN	4045197557421
Item class	21M

Description
Note:

Standard application values for $a_{p\max} \leq 0.5 \times D$.

Technical description

Head length l	32 mm
Flute length L ₂	19 mm
Cutter Ø D	25 mm
Corner chamfer width at 45°	0.5 mm
Feed f _z for side milling in steel < 900 N/mm ²	0.12 mm
Feed f _z for slot milling in steel < 900 N/mm ²	0.09 mm
Arbor size	24 mm
Corner chamfer angle	45 degrees
Series	TopCut
Grade	HB730
Tool material	Solid carbide
Standard	Manufacturer's standard
Type	N

Spacing of the cutters	unequal spacing
Helix angle	40 degrees
Direction of infeed	horizontal, oblique and vertical
Cutting width a_e for milling operation	0.3×D for side milling mm
Cutting width a_e for milling operation	Full slot cutting depth 1×D mm
Machining strategy	HPC
Through-coolant	yes
suitable arbor	GARANT TopCut
Type of product	Cutter insert for milling

User data

	Suitability	V_c	ISO code
Steel < 500 N/mm ²	suitable	210 m/min	P
Steel < 750 N/mm ²	suitable	170 m/min	P
Steel < 900 N/mm ²	suitable	150 m/min	P
Steel < 1100 N/mm ²	suitable	130 m/min	P
Steel < 1400 N/mm ²	suitable only under restricted conditions	110 m/min	P
Steel < 55 HRC	suitable only under restricted conditions	50 m/min	H
Steel < 60 HRC	suitable only under restricted conditions	40 m/min	H
INOX < 900 N/mm ²	suitable	80 m/min	M
INOX > 900 N/mm ²	suitable only under restricted conditions	50 m/min	M
Ti > 850 N/mm ²	suitable only under restricted conditions	80 m/min	S
GG(G)	suitable	160 m/min	K
Oil	suitable only under restricted conditions		
wet maximum	suitable		

wet minimum	suitable only under restricted conditions
dry	suitable only under restricted conditions
Air	suitable

Accessories

Assembly wrench Type 21X5	219987 21X5
Plug-in adapter for torque wrench Type 21X5	219986 21X5