

**Garant**
**Milling head, sharp-edged HPC, uncoated, Ø D h10: 25mm**

**Order data**

|              |               |
|--------------|---------------|
| Order number | 210345 25     |
| GTIN         | 4045197557674 |
| Item class   | 21M           |

**Description**
**Note:**

Standard application values for slots milled from solid at  $a_{p\ max} \leq 0.5 \times D$ .

**Technical description**

|   |                         |
|---|-------------------------|
| Head length l   | 45 mm                   |
| Flute length $L_2$                                      | 25 mm                   |
| Cutter Ø D  | 25 mm                   |
| Feed $f_z$ for side milling in short-chipping aluminium | 0.28 mm                 |
| Feed $f_z$ for slot milling in short-chipping aluminium | 0.22 mm                 |
| Arbor size  | 24 mm                   |
| Corner chamfer angle                                    | 90 degrees              |
| Overall length L  | 71 mm                   |
| Coating   | uncoated                |
| Series  | TopCut                  |
| Grade   | HU730                   |
| Tool material   | Solid carbide           |
| Standard  | Manufacturer's standard |
| Type  | W                       |

|   |                                |
|---|--------------------------------|
| Helix angle                               | 42 degrees                     |
| Direction of infeed                       | horizontal and oblique         |
| 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                           | no                             |
| suitable arbor                            | GARANT TopCut                  |
| Type of product                           | Cutter insert for milling      |

## User data

|                            | Suitability                               | $V_c$     | ISO code |
|----------------------------|---|-----------|----------|
| Alu plastics               | suitable                                  | 530 m/min | N        |
| Aluminium (short chipping) | suitable                                  | 500 m/min | N        |
| Alu > 10% Si               | suitable                                  | 450 m/min | N        |
| CuZn                       | suitable only under restricted conditions | 320 m/min | N        |
| Oil                        | suitable only under restricted conditions |           |          |
| wet maximum                | suitable                                  |           |          |
| wet minimum                | suitable only under restricted conditions |           |          |
| dry                        | suitable only under restricted conditions |           |          |
| Air                        | suitable only under restricted conditions |           |          |

## Accessories

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

