

Garant
PickPocket end milling head, HB730, Ø D h10: 25mm

Order data

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|--------------|---------------|
| Order number | 210050 25 |
| GTIN | 4045197891273 |
| Item class | 21M |

Description
Note:

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

Technical description

| | |
|--|-------------------------|
| Head length l | 32 mm |
| Cutter Ø D | 25 mm |
| Feed f_z for slot milling in steel < 900 N/mm ² | 0.11 mm |
| Flute length L_2 | 19 mm |
| Feed f_z for side milling in steel < 900 N/mm ² | 0.15 mm |
| Arbor size | 24 mm |
| Corner rounding r_v | 0,5 |
| Number of cutting edges Z | 3 |
| Series | GARANT Master Steel |
| Series | TopCut |
| Grade | HB730 |
| Tool material | Solid carbide |
| Standard | Manufacturer's standard |

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|---|----------------------------------|
| Type | N |
| Spacing of the cutters | unequal spacing |
| Helix angle | 38 degrees |
| Helix angle characteristic | unequal spacing |
| 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 | no |
| 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 |

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|-------------|---|
| Oil | suitable only under restricted conditions |
| wet maximum | suitable |
| wet minimum | suitable only under restricted conditions |
| dry | suitable only under restricted conditions |
| Air | suitable |