

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

**Order data**

Order number	203009 25
GTIN	4045197588708
Item class	11X

**Description**
**Version:**

Specially for **machining stainless steels such as duplex steels at high rates of metal removal.**

Cutting edge chamfer: Size 4 = 0.07mm; size 5 – 8 = 0.12 mm; size 10 – 18 = 0.2 mm; ≥ size 20 = 0.3 mm

Tolerance nominal Ø: h10

No. of teeth Z: 6

Helix angle: 38 degrees

Direction of infeed: horizontal, oblique and vertical

Shank: DIN 6535 HB to h6

No. of teeth Z: 6

Flute length  $L_c$ : 45 mm

Overhang length  $L_1$  incl. recess: 60 mm

Recess Ø  $D_1$ : 24.5 mm

Overall length L: 125 mm

Shank Ø  $D_s$ : 25 mm

**Technical description**

Overhang length $L_1$ incl. recess	60 mm
No. of teeth Z	6
Recess Ø $D_1$	24.5 mm
Cutting edge Ø $D_c$	25 mm
Corner chamfer width at 45°	0.3 mm
Feed $f_z$ for slot milling in stainless steel > 900 N/mm <sup>2</sup>	0.07 mm

Feed $f_z$ for side milling in INOX > 900 N/mm <sup>2</sup>	0.1 mm
Shank $\varnothing D_s$	25 mm
Overall length L	125 mm
Flute length $L_c$	45 mm
Direction of infeed	horizontal, oblique and vertical
Shank	DIN 6535 HB to h6
Tolerance nominal $\varnothing$	h10
Helix angle	38 degrees
Corner chamfer angle	45 degrees
Coating	TiAlN
Tool material	Solid carbide
Standard	DIN 6527
Type	N
Helix angle characteristic	unequal spacing
Spacing of the cutters	unequal spacing
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
Machining strategy	HPC
Colour ring	blue
Type of product	End mill

## Services

Shank recess Type FRST	209900 FRST
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