

Garant
GARANT Master Titan HSS-PM roughing end mill HPC, TiAlN, Ø k10 DC / R1: 25/4,0mm

Order data

| | |
|--------------|---------------|
| Order number | 192940 25/4,0 |
| GTIN | 4062406300364 |
| Item class | 11Z |

Description
Version:

Innovative knurled profile and optimised flute geometry for a evacuating a high volume of chips at very high process reliability. Increased tool life due to precise alignment of the through-coolant with the cutting edges.

Advantage:

New type of tool material; problem solver under unstable machining conditions.

Technical description

| | |
|---|----------------------------------|
| Recess $\varnothing D_1$ | 24 mm |
| Shank | DIN 6535 HB to h6 |
| Tolerance nominal \varnothing | k10 |
| Overall length L | 121 mm |
| Cutting edge $\varnothing D_c$ | 25 mm |
| No. of teeth Z | 5 |
| Overhang length L_1 incl. recess | 63 mm |
| Feed f_z for side milling in titanium > 850 N/mm ² | 0.055 mm |
| Direction of infeed | horizontal, oblique and vertical |
| Feed f_z for side milling in INOX > 900 N/mm ² | 0.05 mm |

| | |
|---|------------------------|
| Helix angle | 40 degrees |
| Shank $\varnothing D_s$ | 25 mm |
| Flute length L_c | 45 mm |
| Corner radius R_1 | 4 mm |
| Series | Master Titan |
| Coating | TiAlN |
| Tool material | HSS PM |
| Standard | DIN 844 |
| Milling profile | HR |
| Helix angle characteristic | unequal spacing |
| Spacing of the cutters | unequal spacing |
| Cutting width a_e for milling operation | 0.5×D for side milling |
| Through-coolant | yes |
| Machining strategy | HPC |
| Colour ring | pink |
| Type of product | End / face mill |

User data

| | Suitability | V_c | ISO code |
|------------------------------|-------------|----------|----------|
| INOX < 900 N/mm ² | suitable | 30 m/min | M |
| INOX > 900 N/mm ² | suitable | 28 m/min | M |
| Ti > 850 N/mm ² | suitable | 28 m/min | S |
| wet maximum | suitable | | |