

Garant

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



Order data

Order number	192945 25/4,0
GTIN	4062406300449
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

Tolerance nominal Ø	k10
Helix angle	40 degrees
Feed f_z for side milling in titanium > 850 N/mm ²	0.04 mm
Feed f_z for side milling in INOX > 900 N/mm ²	0.04 mm
Cutting edge Ø D_c	25 mm
Flute length L_c	90 mm
No. of teeth Z	5
Overhang length L_1 incl. recess	108 mm
Direction of infeed	horizontal, oblique and vertical
Shank Ø D_s	25 mm
Overall length L	166 mm

Recess $\varnothing D_1$	24 mm
Shank	DIN 6535 HB to h6
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	$0.3 \times D$ for side milling
Through-coolant	no
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		