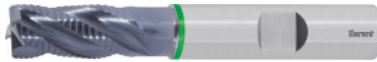


Garant
Solid carbide roughing end mill HPC, TiAlN, Ø d11 DC: 25mm

Order data

Order number	205490 25
GTIN	4045197551627
Item class	11X

Description
Version:
With special knuckle profile.

Dimensions similar to DIN 6527.

For high feed rates, very high metal removal rate.

Note:
NEW GENERATION AVAILABLE!

Recommended successor product No. 205550.

Technical description

Overhang length L_1 incl. recess	65 mm
Feed f_z for side milling in steel $< 900 \text{ N/mm}^2$	0.14 mm
Feed f_z for slot milling in steel $< 900 \text{ N/mm}^2$	0.12 mm
Recess $\varnothing D_1$	24 mm
Cutting edge $\varnothing D_c$	25 mm
Corner chamfer width at 45°	0.5 mm
No. of teeth Z	5
Shank $\varnothing D_s$	25 mm
Overall length L	121 mm
Flute length L_c	45 mm
Direction of infeed	horizontal, oblique and vertical

Shank	DIN 6535 HB to h6
Tolerance nominal \varnothing	d11
Helix angle	30 degrees
Corner chamfer angle	45 degrees
Coating	TiAlN
Tool material	Solid carbide
Standard	DIN 6527
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
Cutting width a_e for milling operation	Full slot cutting depth 1×D
Through-coolant	no
Machining strategy	HPC
Colour ring	green
Type of product	End / face mill

User data

	Suitability	V_c	ISO code
Aluminium (short chipping)	suitable only under restricted conditions	280 m/min	N
Alu > 10% Si	suitable only under restricted conditions	200 m/min	N
Steel < 500 N/mm ²	suitable	120 m/min	P
Steel < 750 N/mm ²	suitable	105 m/min	P
Steel < 900 N/mm ²	suitable	100 m/min	P
Steel < 1100 N/mm ²	suitable	70 m/min	P
Steel < 1400 N/mm ²	suitable	60 m/min	P
Steel < 55 HRC	suitable only under restricted conditions	35 m/min	H

INOX < 900 N/mm ²	suitable	60 m/min	M
INOX > 900 N/mm ²	suitable	50 m/min	M
GG(G)	suitable	90 m/min	K
Uni	suitable		
wet maximum	suitable		
wet minimum	suitable only under restricted conditions		
dry	suitable only under restricted conditions		
Air	Suitable only under restricted conditions		