



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



### Order data

Order number	205492 25
GTIN	4045197546159
Item class	12X

### Description

#### Version:

Dimensions similar to DIN 6527.

For high feed rates, very high metal removal rate.

Without dynamic twist pitch.

Size **16M MID mills: Dimensions to manufacturer's standard.**

#### Note:

**NEW GENERATION AVAILABLE!**

**Recommended successor product No. 205706.**

### Technical description

Feed $f_z$ for slot milling in steel $< 900 \text{ N/mm}^2$	0.12 mm
Cutting edge $\varnothing D_c$	25 mm
Corner chamfer width at $45^\circ$	0.5 mm
Feed $f_z$ for side milling in steel $< 900 \text{ N/mm}^2$	0.14 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
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	without
Type of product	End / face mill

## User data

	Suitability	$V_c$	ISO code
Aluminium (short chipping)	suitable only under restricted conditions	270 m/min	N
Alu > 10% Si	suitable only under restricted conditions	190 m/min	N
Steel < 500 N/mm <sup>2</sup>	suitable	115 m/min	P
Steel < 750 N/mm <sup>2</sup>	suitable	100 m/min	P
Steel < 900 N/mm <sup>2</sup>	suitable	95 m/min	P
Steel < 1100 N/mm <sup>2</sup>	suitable	65 m/min	P
Steel < 1400 N/mm <sup>2</sup>	suitable	55 m/min	P
INOX < 900 N/mm <sup>2</sup>	suitable only under restricted conditions	55 m/min	M
GG(G)	suitable	85 m/min	K
Uni	suitable only under restricted conditions		
wet maximum	suitable		

wet minimum	suitable only under restricted conditions
dry	suitable only under restricted conditions
Air	Suitable only under restricted conditions