

Garant
Solid carbide roughing end mill HPC, TiAlN, Ø d11 DC: 12mm

Order data

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|--------------|---------------|
| Order number | 205490 12 |
| GTIN | 4045197551566 |
| 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

| | |
|-------------------------------------------------------------|----------------------------------|
| Feed f_z for slot milling in steel $< 900 \text{ N/mm}^2$ | 0.06 mm |
| No. of teeth Z | 4 |
| Cutting edge $\varnothing D_c$ | 12 mm |
| Overhang length L_1 incl. recess | 38 mm |
| Feed f_z for side milling in steel $< 900 \text{ N/mm}^2$ | 0.08 mm |
| Corner chamfer width at 45° | 0.5 mm |
| Recess $\varnothing D_1$ | 11 mm |
| Shank $\varnothing D_s$ | 12 mm |
| Overall length L | 83 mm |
| Flute length L_c | 26 mm |
| Direction of infeed | horizontal, oblique and vertical |

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|-------------------------------------------|-----------------------------|
| 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 | | |