

**Garant**
**End mill HSS-PM, TiAlN, Ø k10 DC: 25Mmm**

**Order data**

|              |               |
|--------------|---------------|
| Order number | 191520 25M    |
| GTIN         | 4045197103338 |
| Item class   | 11W           |

**Description**
**Version:**

Multi-flute end mill. **Eccentric relief ground.**

For the highest demands in respect to material removal rates.

**Excellent results** when **milling dry.**

Size 6M–25M **MID mills:**

Dimensions to **manufacturer's standard**, which lies **between** DIN 844 **short** and DIN 844 **long**.

**Particularly suitable** for **mould** and **tool making**, as the **medium length** provides higher **rigidity** than long series mills to DIN 844.

**Technical description**

|   |                                  |
|---|----------------------------------|
| No. of teeth Z  | 6                                |
| Cutting edge Ø D <sub>c</sub>   | 25 mm                            |
| Feed f <sub>z</sub> for slot milling in steel < 750 N/mm <sup>2</sup> | 0.046 mm                         |
| Shank Ø D <sub>s</sub>  | 25 mm                            |
| Overall length L  | 144 mm                           |
| Flute length L <sub>c</sub>   | 68 mm                            |
| Direction of infeed   | horizontal, oblique and vertical |
| Shank   | DIN 1835 B to h6                 |
| Tolerance nominal Ø   | k10                              |
| Helix angle   | 30-40 degrees                    |
| Corner chamfer angle  | 90 degrees                       |

|                 |                 |
|-----------------|-----------------|
| Coating         | TiAlN           |
| Tool material   | HSS PM          |
| Standard        | DIN 844 B       |
| Type            | N               |
| Through-coolant | no              |
| Colour ring     | without         |
| Type of product | End / face mill |

### User data

|                                | Suitability                               | V <sub>c</sub> | ISO code |
|--------------------------------|---|----------------|----------|
| Aluminium (short chipping)     | suitable only under restricted conditions | 138 m/min      | N        |
| Alu > 10% Si                   | suitable only under restricted conditions | 110 m/min      | N        |
| Steel < 500 N/mm <sup>2</sup>  | suitable                                  | 83 m/min       | P        |
| Steel < 750 N/mm <sup>2</sup>  | suitable                                  | 64 m/min       | P        |
| Steel < 900 N/mm <sup>2</sup>  | suitable                                  | 64 m/min       | P        |
| Steel < 1100 N/mm <sup>2</sup> | suitable                                  | 37 m/min       | P        |
| Steel < 1400 N/mm <sup>2</sup> | suitable only under restricted conditions | 32 m/min       | P        |
| INOX < 900 N/mm <sup>2</sup>   | suitable                                  | 23 m/min       | M        |
| INOX > 900 N/mm <sup>2</sup>   | suitable only under restricted conditions | 18 m/min       | M        |
| GG(G)                          | suitable only under restricted conditions | 55 m/min       | K        |
| CuZn                           | suitable only under restricted conditions | 110 m/min      | N        |
| Uni                            | suitable                                  |                |          |
| wet maximum                    | suitable                                  |                |          |
| dry                            | suitable                                  |                |          |

