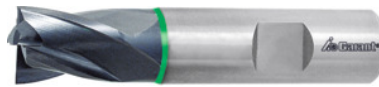


Garant
End mill HSS-E-SPM HPC, TiAlN, Ø k10 DC: 22mm

Order data

Order number	191632 22
GTIN	4045197199072
Item class	11W

Description
Version:

Special **SPM** substrate with very high cobalt content.

Combines the **hardness of solid carbide** and the **toughness of PM steel**.

Dimensions to DIN 327.

Advantage:

This end mill can be used on a wide range of materials due to the universal geometry.

Technical description

No. of teeth Z	4
Feed f_z for side milling in steel < 1100 N/mm ²	0.044 mm
Cutting edge Ø D_c	22 mm
Shank Ø D_s	20 mm
Overall length L	88 mm
Flute length L_c	22 mm
Direction of infeed	horizontal, oblique and vertical
Shank	DIN 1835 B to h6
Tolerance nominal Ø	k10
Helix angle	25 degrees
Corner chamfer angle	90 degrees
Coating	TiAlN

Tool material	HSS E SPM
Standard	DIN 327
Type	N
Helix angle characteristic	unequal spacing
Cutting width a_e for milling operation	$0.5 \times D$ for side milling
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	159 m/min	N
Alu > 10% Si	suitable only under restricted conditions	125 m/min	N
Steel < 500 N/mm ²	suitable	95 m/min	P
Steel < 750 N/mm ²	suitable	74 m/min	P
Steel < 900 N/mm ²	suitable	74 m/min	P
Steel < 1100 N/mm ²	suitable	42 m/min	P
Steel < 1400 N/mm ²	suitable	32 m/min	P
INOX < 900 N/mm ²	suitable	26 m/min	M
INOX > 900 N/mm ²	suitable	21 m/min	M
GG(G)	suitable only under restricted conditions	63 m/min	K
CuZn	suitable only under restricted conditions	125 m/min	N
Uni	suitable		
wet maximum	suitable		
dry	suitable		

Air

suitable