

## Garant

### Semi-roughing end mill, TiAlN, Ø k12 DC: 8mm



## Order data

|              |               |
|--------------|---------------|
| Order number | 191720 8      |
| GTIN         | 4045197104922 |
| Item class   | 11W           |

## Description

### Version:

Size 10 – 30 centre cutting teeth for plunging.

or a considerable performance improvement with special ground **chip breaker flutes**.

### Advantage:

The chip breaker flutes **facilitate chip evacuation** and at the same time ensure a **good component surface finish**.

## Technical description

|   |                        |
|---|------------------------|
| No. of teeth Z  | 4                      |
| Cutting edge Ø D <sub>c</sub>   | 8 mm                   |
| Feed f <sub>z</sub> for slot milling in steel < 750 N/mm <sup>2</sup> | 0.018 mm               |
| Shank Ø D <sub>s</sub>  | 10 mm                  |
| Overall length L  | 69 mm                  |
| Flute length L <sub>c</sub>   | 19 mm                  |
| Direction of infeed   | horizontal and oblique |
| Shank   | DIN 1835 B to h6       |
| Tolerance nominal Ø   | k12                    |
| Helix angle   | 27-30 degrees          |
| Corner chamfer angle  | 90 degrees             |
| Coating   | TiAlN                  |

|                 |                 |
|-----------------|-----------------|
| Tool material   | HSS Co 8        |
| Standard        | DIN 844 B       |
| Milling profile | NF              |
| 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 | 120 m/min      | N        |
| Steel < 500 N/mm <sup>2</sup> | suitable                                  | 78 m/min       | P        |
| Steel < 750 N/mm <sup>2</sup> | suitable                                  | 55 m/min       | P        |
| Steel < 900 N/mm <sup>2</sup> | suitable                                  | 55 m/min       | P        |
| INOX < 900 N/mm <sup>2</sup>  | suitable                                  | 17 m/min       | M        |
| INOX > 900 N/mm <sup>2</sup>  | suitable only under restricted conditions | 14 m/min       | M        |
| GG(G)                         | suitable only under restricted conditions | 46 m/min       | K        |
| CuZn                          | suitable only under restricted conditions | 92 m/min       | N        |
| Uni                           | suitable                                  |                |          |
| wet maximum                   | suitable                                  |                |          |
| dry                           | suitable only under restricted conditions |                |          |