

**Garant**
**Semi-roughing end mill, uncoated, Ø k12 DC: 22mm**

**Order data**

Order number	191710 22
GTIN	4045197104830
Item class	11W

**Description**

**Version:**  
Relief ground fine pitch semi-roughing profile.

**Technical description**

Cutting edge $\varnothing D_c$	22 mm
Feed $f_z$ for slot milling in steel $< 750 \text{ N/mm}^2$	0.06 mm
No. of teeth Z	5
Shank $\varnothing D_s$	20 mm
Overall length L	104 mm
Flute length $L_c$	38 mm
Direction of infeed	horizontal and oblique
Shank	DIN 1835 B to h6
Tolerance nominal $\varnothing$	k12
Helix angle	27-30 degrees
Corner chamfer angle	90 degrees
Coating	uncoated
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	83 m/min	N
Steel < 500 N/mm <sup>2</sup>	suitable	30 m/min	P
Steel < 750 N/mm <sup>2</sup>	suitable	25 m/min	P
Steel < 900 N/mm <sup>2</sup>	suitable only under restricted conditions	25 m/min	P
GG(G)	suitable only under restricted conditions	23 m/min	K
CuZn	suitable only under restricted conditions	55 m/min	N
Uni	suitable		
wet maximum	suitable		