Garant

Roughing end mill HSS-PM, TiAlN, ∅ js12 DC: 9mm

Order data

Order number	192445 9
GTIN	4045197106087
Item class	11W

Description

Version:
Relief ground knuckle form profile.
Centre cutting teeth for plunging.
Universal end mills for profile milling or for plunging.
For the most demanding metal removal rates.
Advantage:
Compared to multi–flute cutters, **better chip evacuation due to larger flutes.**

Technical description

Feed f_z for slot milling in steel < 750 N/mm^2	0.015 mm
Corner chamfer width at 45°	0.4 mm
Cutting edge ∅ D_C	9 mm
No. of teeth Z	3
Shank ∅ D_s	10 mm
Overall length L	69 mm
Flute length L_c	19 mm
Direction of infeed	horizontal, oblique and vertical
Shank	DIN 1835 B to h6
Tolerance nominal ∅	js12
Helix angle	25 degrees

Corner chamfer angle	45 degrees
Coating	TiAlN
Tool material	HSS PM
Standard	DIN 844 B
Milling profile	NR
Through-coolant	no
Colour ring	without
Type of product	End / face mill

User data

	Suitability	V_c	ISO code
Aluminium (short chipping)	suitable only under restricted conditions	138 m/min	N
Steel < 500 N/mm²	suitable	83 m/min	P
Steel < 750 N/mm²	suitable	64 m/min	P
Steel < 900 N/mm²	suitable	64 m/min	P
Steel < 1100 N/mm²	suitable	37 m/min	P
Steel < 1400 N/mm²	suitable only under restricted conditions	32 m/min	P
INOX < 900 N/mm²	suitable	23 m/min	M
INOX > 900 N/mm²	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		