

Garant
Roughing end mill HSS-PM, TiAlN, Ø DC: 28mm

Order data

| | |
|--------------|---------------|
| Order number | 192645 28 |
| GTIN | 4045197107411 |
| Item class | 11W |

Description
Version:
With relief ground knuckle form profile.

Up to size 20 with end cutting teeth profile for plunging.

The wide teeth lands permit multiple re-grinding without losing the profile.

HSS-PM – For highest demands on metal removal rates.

Sizes 6M to 25M – **MID mills:** dimensions to **factory standard, which is between DIN 844 stub and DIN 844 long.**

Through-coolant: no

Tolerance nominal Ø: js12

No. of teeth Z: 5

Helix angle: 30°

Direction of infeed: horizontal and oblique

Shank: DIN 1835 B to h6

No. of teeth Z: 5

Flute length L_c : 45 mm

Overall length L: 121 mm

Shank Ø D_s : 25 mm

Corner chamfer width at 45°: 0.7 mm

Feed f_z for slot milling in steel < 750 N/mm²: 0.08 mm

Technical description

| | |
|-----------------------------|--------|
| Cutting edge Ø D_c | 28 mm |
| No. of teeth Z | 5 |
| Corner chamfer width at 45° | 0.7 mm |

| | |
|--|------------------------|
| Feed f_z for slot milling in steel < 750 N/mm ² | 0.08 mm |
| Shank $\varnothing D_s$ | 25 mm |
| Overall length L | 121 mm |
| Flute length L_c | 45 mm |
| Direction of infeed | horizontal and oblique |
| Shank | DIN 1835 B to h6 |
| Tolerance nominal \varnothing | js12 |
| Helix angle | 30° |
| Corner chamfer angle | 45° |
| 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/mm ² | suitable | 83 m/min | P |
| Steel < 750 N/mm ² | suitable | 64 m/min | P |
| Steel < 900 N/mm ² | suitable | 64 m/min | P |
| Steel < 1100 N/mm ² | suitable | 37 m/min | P |
| Steel < 1400 N/mm ² | suitable only under restricted conditions | 32 m/min | P |
| INOX < 900 N/mm ² | suitable | 23 m/min | M |
| INOX > 900 N/mm ² | 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 | | |