



## Roughing end mill HSS-Co8, TiAlN, Ø DC: 25Mmm



### Order data

Order number	192650 25M
GTIN	4045197107664
Item class	12W

### 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.

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

Economy version.

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  $L_c$ : 68 mm

Overall length L: 144 mm

Shank Ø  $D_s$ : 25 mm

Corner chamfer width at 45°: 0.6 mm

Feed  $f_z$  for slot milling in steel < 750 N/mm<sup>2</sup>: 0.031 mm

### Technical description

Corner chamfer width at 45°	0.6 mm
Cutting edge Ø $D_c$	25 mm
No. of teeth Z	5

Feed $f_z$ for slot milling in steel < 750 N/mm <sup>2</sup>	0.031 mm
Shank $\varnothing D_s$	25 mm
Overall length L	144 mm
Flute length $L_c$	68 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 Co 8
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	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
Steel < 1100 N/mm <sup>2</sup>	suitable	29 m/min	P
Steel < 1400 N/mm <sup>2</sup>	suitable only under restricted conditions	25 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		