

Garant
Roughing end mill HPC HSS-E-SPM, TiAlN, Ø k12 DC: 16mm

Order data

| | |
|--------------|---------------|
| Order number | 192855 16 |
| GTIN | 4045197108302 |
| Item class | 11W |

Description
Version:

Special **SPM** substrate with very high cobalt content.

Combines the **hardness of solid carbide** and the **toughness of PM steel**.

Centre cutting teeth profile for plunging.

Application:

For very high metal removal rates and increased machining volumes on stainless steels.

Technical description

| | |
|---|----------------------------------|
| Cutting edge $\varnothing D_c$ | 16 mm |
| Feed f_z for slot milling in stainless steel $> 900 \text{ N/mm}^2$ | 0.034 mm |
| Corner chamfer width at 45° | 0.3 mm |
| No. of teeth Z | 5 |
| Shank $\varnothing D_s$ | 16 mm |
| Overall length L | 92 mm |
| Flute length L_c | 32 mm |
| Direction of infeed | horizontal, oblique and vertical |
| Shank | DIN 1835 B to h6 |
| Tolerance nominal \varnothing | k12 |
| Helix angle | 30 degrees |
| Corner chamfer angle | 45 degrees |

| | |
|--------------------|-----------------|
| Coating | TiAlN |
| Tool material | HSS E SPM |
| Standard | DIN 844 |
| Milling profile | HRF |
| Through-coolant | no |
| Machining strategy | HPC |
| Colour ring | blue |
| Type of product | End / face mill |

User data

| | Suitability | V _c | ISO code |
|--------------------------------|---|----------------|----------|
| Aluminium (short chipping) | suitable only under restricted conditions | 159 m/min | N |
| Steel < 500 N/mm ² | suitable | 95 m/min | P |
| Steel < 750 N/mm ² | suitable | 74 m/min | P |
| Steel < 900 N/mm ² | suitable | 74 m/min | P |
| Steel < 1100 N/mm ² | suitable only under restricted conditions | 42 m/min | P |
| INOX < 900 N/mm ² | suitable | 26 m/min | M |
| INOX > 900 N/mm ² | suitable | 21 m/min | M |
| Ti > 850 N/mm ² | suitable | 20 m/min | S |
| Uni | suitable only under restricted conditions | | |
| wet maximum | suitable | | |
| wet minimum | suitable | | |
| dry | suitable only under restricted conditions | | |