

Garant
Roughing end mill HSS-PM, TiAlN, Ø DC: 16mm

Order data

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|--------------|---------------|
| Order number | 192860 16 |
| GTIN | 4045197108531 |
| Item class | 11W |

Description
Version:
Relief ground fine pitch knuckle form profile.

Centre cutting teeth for plunging.

Size 6M to 25M – **MID mills:** Dimensions to **manufacturer's standard**, which is **between** DIN 844 **stub** and DIN 844 **long**.

Technical description

| | |
|---|----------------------------------|
| No. of teeth Z | 5 |
| Overhang length L_1 incl. recess | 43 mm |
| Recess $\varnothing D_1$ | 15.5 mm |
| Feed f_z for slot milling in steel $< 900 \text{ N/mm}^2$ | 0.041 mm |
| Corner chamfer width at 45° | 0.3 mm |
| Cutting edge $\varnothing D_c$ | 16 mm |
| 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 | ± 0.12 |
| Helix angle | 30 degrees |

| | |
|----------------------|-----------------|
| Corner chamfer angle | 45 degrees |
| Coating | TiAlN |
| Tool material | HSS PM |
| Standard | DIN 844 |
| Milling profile | HR |
| Through-coolant | no |
| Colour ring | green |
| 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 | 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 | | |