

Garant
Roughing end mill HSS-Co8, TiAlN, Ø k12 DC: 20Mmm

Order data

Order number	192605 20M
GTIN	4067263290964
Item class	11W

Description
Version:

Sizes 6M to 25M – **MID mills**. Dimensions to **factory standard, between** DIN 844 **short** and DIN 844 **long**.

With relief ground knuckle profile. The wide teeth lands permit multiple re-grinding without losing the profile.

End face geometry for plunging and unequal spacing of the teeth.

Technical description

Direction of infeed	horizontal, oblique and vertical
Helix angle	30 degrees
Overall length L	122 mm
Shank Ø D _s	20 mm
Tolerance nominal Ø	k12
Shank	DIN 1835 B to h6
No. of teeth Z	4
Corner chamfer angle	45 degrees
Corner chamfer width at 45°	0.5 mm
Cutting edge Ø D _c	20 mm
Feed f _z for slot milling in steel < 750 N/mm ²	0.031 mm
Flute length L _c	58 mm

Coating	TiAlN
Tool material	HSS Co 8
Standard	DIN 844 B
Milling profile	NR
Spacing of the cutters	unequal spacing
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 ²	suitable	781 m/min	P
Steel < 750 N/mm ²	suitable	55 m/min	P
Steel < 900 N/mm ²	suitable	55 m/min	P
Steel < 1100 N/mm ²	suitable	29 m/min	P
Steel < 1400 N/mm ²	suitable only under restricted conditions	25 m/min	P
INOX < 900 N/mm ²	suitable	17 m/min	M
INOX > 900 N/mm ²	suitable	14 m/min	M
GG(G)	suitable only under restricted conditions	46 m/min	K
CuZn	suitable only under restricted conditions	90 m/min	N
Uni	suitable		
wet maximum	suitable		
dry	suitable only under restricted conditions		

