

Garant

Roughing end mill HSS-Co8, TiAlN, Ø k12 DC: 28mm



Order data

| | |
|--------------|---------------|
| Order number | 192605 28 |
| GTIN | 4067263291008 |
| 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

| | |
|---|----------------------------------|
| Feed f_z for slot milling in steel $< 750 \text{ N/mm}^2$ | 0.031 mm |
| Helix angle | 30 degrees |
| No. of teeth Z | 5 |
| Flute length L_c | 45 mm |
| Corner chamfer angle | 45 degrees |
| Corner chamfer width at 45° | 0.5 mm |
| Shank | DIN 1835 B to h6 |
| Direction of infeed | horizontal, oblique and vertical |
| Tolerance nominal \varnothing | k12 |
| Cutting edge $\varnothing D_c$ | 28 mm |
| Overall length L | 121 mm |
| Shank $\varnothing D_s$ | 25 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 | | |

