

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

Order data

Order number	192610 28
GTIN	4067263291183
Item class	11W

Description
Version:

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

Flute length L_c	90 mm
Cutting edge $\varnothing D_c$	28 mm
Overall length L	166 mm
Feed f_z for side milling in steel $< 750 \text{ N/mm}^2$	0.061 mm
Shank $\varnothing D_s$	25 mm
Corner chamfer angle	45 degrees
Helix angle	30 degrees
Corner chamfer width at 45°	0.5 mm
No. of teeth Z	5
Shank	DIN 1835 B to h6
Tolerance nominal \varnothing	k12
Direction of infeed	horizontal, oblique and vertical
Coating	TiAlN
Tool material	HSS Co 8

Standard	DIN 844 B
Milling profile	NR
Spacing of the cutters	unequal spacing
Cutting width a_e for milling operation	$0.15 \times D$ for side milling
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	100 m/min	N
Steel < 500 N/mm ²	suitable	60 m/min	P
Steel < 750 N/mm ²	suitable	45 m/min	P
Steel < 900 N/mm ²	suitable	45 m/min	P
INOX < 900 N/mm ²	suitable	13 m/min	M
INOX > 900 N/mm ²	suitable only under restricted conditions	11 m/min	M
GG(G)	suitable only under restricted conditions	36 m/min	K
CuZn	suitable only under restricted conditions	73 m/min	N
Uni	suitable		
wet maximum	suitable		
dry	suitable only under restricted conditions		