

**Garant**
**Solid carbide end mill HPC, DLC, Ø f8 DC: 16mm**

**Order data**

Order number	202552 16
GTIN	4045197948298
Item class	11X

**Description**
**Version:**

Sturdy roughing end mill **without** knuckle profile.

With strong core, **special chip breaker recesses** and **large polished flutes**.

**Application:**

For roughing milling with high demands on the component surface.

**Technical description**

Flute length $L_c$	48 mm
Corner chamfer width at 45°	0.2 mm
Shank Ø $D_s$	16 mm
Tolerance nominal Ø	f8
Recess Ø $D_1$	15 mm
No. of teeth $Z$	4
Feed $f_z$ for slot milling in short-chipping aluminium	0.12 mm
Shank form	HA
Cutting edge Ø $D_c$	16 mm
Shank	DIN 6535 HA to h6
Overhang length $L_1$ incl. recess	58 mm
Helix angle	45 degrees
Direction of infeed	horizontal, oblique and vertical

Feed $f_z$ for side milling in short-chipping aluminium	0.14 mm
Overall length L	108 mm
Corner chamfer angle	45 degrees
Coating	DLC
Tool material	Solid carbide
Standard	Manufacturer's standard
Type	W
Helix angle characteristic	unequal spacing
Spacing of the cutters	unequal spacing
Cutting width $a_e$ for milling operation	$0.3 \times D$ for side milling
Through-coolant	no
Machining strategy	HPC
Colour ring	yellow
Type of product	End / face mill

## User data

	Suitability	$V_c$	ISO code
Aluminium	Suitable	480 m/min	N
Aluminium (short chipping)	suitable	440 m/min	N
Alu > 10% Si	suitable	400 m/min	N
PMMA acrylic	Suitable	200 m/min	N
PE-HD	Suitable	160 m/min	N
PA 66	Suitable	200 m/min	N
PEEK	Suitable	150 m/min	N
PF 31	Suitable	130 m/min	N
PVDF GF20	suitable	180 m/min	N
POM GF25	Suitable	160 m/min	N
PA 66 GF30	suitable	150 m/min	N

PEEK GF30	suitable	130 m/min	N
PTFE CF25	suitable	160 m/min	N
Hybrids	suitable only under restricted conditions	m/min	N
Honeycomb sandwich	suitable only under restricted conditions	300 m/min	N
Cu	Suitable	160 m/min	N
CuZn	Suitable	200 m/min	N
wet maximum	suitable		
wet minimum	suitable		
dry	suitable only under restricted conditions		
Air	Suitable		
<b>Services</b>			

Shank grinding Type HB

129100 HB