

Garant
End mill HSS-PM, TiAlN, Ø k10 DC: 6mm

Order data

Order number	191581 6
GTIN	4045197973757
Item class	11W

Description
Version:

Multi-flute end mill, for highest metal removal rate demands. Centre cutting edge geometry for plunging. **Eccentric relief ground**. For peripheral milling as a finishing operation, **producing very high surface finish quality**.

Advantage:

Excellent results when **milling dry**.

Technical description

Helix angle	50 degrees
Overhang length L_1 incl. recess	21 mm
Recess $\varnothing D_1$	5.7 mm
Overall length L	57 mm
Feed f_z for slot milling in steel $< 750 \text{ N/mm}^2$	0.016 mm
Tolerance nominal \varnothing	k10
Flute length L_c	13 mm
Shank	DIN 1835 B to h6
No. of teeth Z	4
Cutting edge $\varnothing D_c$	6 mm
Corner chamfer width at 45°	0.2 mm
Direction of infeed	horizontal, oblique and vertical

Shank $\varnothing D_s$	6 mm
Corner chamfer angle	45 degrees
Coating	TiAlN
Tool material	HSS PM
Standard	DIN 844 B
Type	N
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	138 m/min	N
Alu > 10% Si	suitable only under restricted conditions	110 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 only under restricted conditions	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
Air	suitable