

Garant
End mill HSS-PM, TiAlN, Ø k10 DC: 12mm

Order data

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|--------------|---------------|
| Order number | 191581 12 |
| GTIN | 4045197973788 |
| 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

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| Recess Ø D ₁ | 11.5 mm |
| No. of teeth Z | 4 |
| Helix angle | 50 degrees |
| Shank | DIN 1835 B to h6 |
| Overall length L | 83 mm |
| Tolerance nominal Ø | k10 |
| Feed f _z for slot milling in steel < 750 N/mm ² | 0.058 mm |
| Overhang length L ₁ incl. recess | 38 mm |
| Shank Ø D _s | 12 mm |
| Cutting edge Ø D _c | 12 mm |
| Flute length L _c | 26 mm |
| Corner chamfer width at 45° | 0.25 mm |

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| Direction of infeed | horizontal, oblique and vertical |
| 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 | | |

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|-----|----------|
| dry | suitable |
| Air | suitable |