

Garant
Roughing end mill HPC HSS-E-SPM, TiAlN, Ø k12 DC: 6mm

Order data

Order number	192855 6
GTIN	4045197363015
Item class	11W

Description
Version:

Special **SPM** substrate with very high cobalt content.

Combines the **hardness of solid carbide** and the **toughness of PM steel**.

Centre cutting teeth profile for plunging.

Application:

For very high metal removal rates and increased machining volumes on stainless steels.

Technical description

No. of teeth Z	3
Corner chamfer width at 45°	0.3 mm
Feed f_z for slot milling in stainless steel > 900 N/mm ²	0.008 mm
Cutting edge Ø D_c	6 mm
Shank Ø D_s	6 mm
Overall length L	57 mm
Flute length L_c	13 mm
Direction of infeed	horizontal, oblique and vertical
Shank	DIN 1835 B to h6
Tolerance nominal Ø	k12
Helix angle	30 degrees
Corner chamfer angle	45 degrees

Coating	TiAlN
Tool material	HSS E SPM
Standard	DIN 844
Milling profile	HRF
Through-coolant	no
Machining strategy	HPC
Colour ring	blue
Type of product	End / face mill

User data

	Suitability	V _c	ISO code
Aluminium (short chipping)	suitable only under restricted conditions	159 m/min	N
Steel < 500 N/mm ²	suitable	95 m/min	P
Steel < 750 N/mm ²	suitable	74 m/min	P
Steel < 900 N/mm ²	suitable	74 m/min	P
Steel < 1100 N/mm ²	suitable only under restricted conditions	42 m/min	P
INOX < 900 N/mm ²	suitable	26 m/min	M
INOX > 900 N/mm ²	suitable	21 m/min	M
Ti > 850 N/mm ²	suitable	20 m/min	S
Uni	suitable only under restricted conditions		
wet maximum	suitable		
wet minimum	suitable		
dry	suitable only under restricted conditions		