

Garant
End mill HSS-PM, TiAlN, Ø k10 DC: 25mm

Order data

Order number	191581 25
GTIN	4045197973832
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

Tolerance nominal Ø	k10
Shank	DIN 1835 B to h6
Flute length L_c	45 mm
Recess Ø D_1	24 mm
Overall length L	121 mm
Helix angle	50 degrees
Feed f_z for slot milling in steel < 750 N/mm ²	0.076 mm
Overhang length L_1 incl. recess	65 mm
Corner chamfer width at 45°	0.3 mm
No. of teeth Z	4
Shank Ø D_s	25 mm
Cutting edge Ø D_c	25 mm

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		

dry	suitable
Air	suitable