

Garant

Solid carbide roughing end mill with internal coolant supply HPC, TiAlN, Ø d11 DC: 12mm



Order data

Order number	205592 12
GTIN	4045197553171
Item class	11X

Description

Version:

With internal coolant supply.

The coolant is fed directly **to the cutting** edges.

This gives **longer tool-life** and **complete swarf evacuation**.

This is especially **important when milling slots or pockets**.

Technical description

Corner chamfer width at 45°	0.5 mm
Cutting edge Ø D _c	12 mm
Feed f _z for slot milling in steel < 900 N/mm ²	0.06 mm
Feed f _z for side milling in steel < 900 N/mm ²	0.08 mm
No. of teeth Z	4
Shank Ø D _s	12 mm
Overall length L	83 mm
Flute length L _c	26 mm
Direction of infeed	horizontal, oblique and vertical
Shank	DIN 6535 HB to h6
Tolerance nominal Ø	d11
Helix angle	20 degrees

Corner chamfer angle	45 degrees
Coating	TiAlN
Tool material	Solid carbide
Standard	DIN 6527
Milling profile	HR
Cutting width a_e for milling operation	0.3×D for side milling
Cutting width a_e for milling operation	Full slot cutting depth 1×D
Through-coolant	yes
Machining strategy	HPC
Colour ring	green
Type of product	End / face mill

User data

	Suitability	V_c	ISO code
Aluminium (short chipping)	suitable only under restricted conditions	280 m/min	N
Alu > 10% Si	suitable only under restricted conditions	200 m/min	N
Steel < 500 N/mm ²	suitable	120 m/min	P
Steel < 750 N/mm ²	suitable	105 m/min	P
Steel < 900 N/mm ²	suitable	100 m/min	P
Steel < 1100 N/mm ²	suitable	70 m/min	P
Steel < 1400 N/mm ²	suitable	60 m/min	P
Steel < 55 HRC	suitable only under restricted conditions	35 m/min	H
INOX < 900 N/mm ²	suitable	60 m/min	M
INOX > 900 N/mm ²	suitable	50 m/min	M
GG(G)	suitable	90 m/min	K
Uni	suitable		
wet maximum	suitable		

Air

suitable