

Garant
GARANT Master Steel solid carbide roughing end mill HPC, TiAlN, Ø f8 DC: 18mm

Order data

Order number	203035 18
GTIN	4045197718822
Item class	11X

Description
Version:

For **roughing and finishing**.

Up to 1.5xD into solid material **at very high feed rates** with smooth cutting action.

Advantage:

Optimised flute form, eccentric relief ground, wide chip space.

Technical description

Recess $\varnothing D_1$	17.8 mm
Cutting edge $\varnothing D_c$	18 mm
No. of teeth Z	4
Overhang length L_1 incl. recess	42 mm
Feed f_z for side milling in steel < 900 N/mm ²	0.13 mm
Feed f_z for slot milling in steel < 900 N/mm ²	0.1 mm
Corner chamfer width at 45°	0.36 mm
Shank $\varnothing D_s$	18 mm
Overall length L	92 mm
Flute length L_c	36 mm
Direction of infeed	horizontal, oblique and vertical
Shank	DIN 6535 HB to h6

Tolerance nominal \varnothing	f8
Helix angle	38 degrees
Corner chamfer angle	45 degrees
Series	Master Steel
Coating	TiAlN
Tool material	Solid carbide
Standard	DIN 6527
Type	N
Helix angle characteristic	unequal spacing
Spacing of the cutters	unequal spacing
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	no
Machining strategy	HPC
Colour ring	green
Type of product	End / face mill

User data

	Suitability	V_c	ISO code
Steel < 500 N/mm ²	suitable	260 m/min	P
Steel < 750 N/mm ²	suitable	240 m/min	P
Steel < 900 N/mm ²	suitable	190 m/min	P
Steel < 1100 N/mm ²	suitable	180 m/min	P
Steel < 1400 N/mm ²	suitable only under restricted conditions	150 m/min	P
INOX < 900 N/mm ²	suitable	80 m/min	M
INOX > 900 N/mm ²	suitable	70 m/min	M
GG(G)	suitable	250 m/min	K
Uni	suitable		

wet maximum	suitable
wet minimum	suitable only under restricted conditions
dry	suitable
Air	suitable