



Solid carbide roughing end mill HPC, uncoated, Ø e8 DC: 18mm



Order data

Order number	205260 18
GTIN	4062406122515
Item class	12X

Description

Version:

For roughing.
Special profile for machining non-ferrous metals.

Technical description

Shank	DIN 6535 HA to h6
Cutting edge Ø D _c	18 mm
Tolerance nominal Ø	e8
Feed f _z for side milling in short-chipping aluminium	0.25 mm
Feed f _z for slot milling in short-chipping aluminium	0.22 mm
No. of teeth Z	3
Shank Ø D _s	18 mm
Helix angle	45 degrees
Flute length L _c	31 mm
Overall length L	92 mm
Overhang length L ₁ incl. recess	42 mm
Direction of infeed	horizontal, oblique and vertical
Recess Ø D ₁	17 mm
Corner rounding r _v	0.32 mm

Coating	uncoated
Tool material	Solid carbide
Standard	DIN 6527
Milling profile	WR
Cutting width a_e for milling operation	0.5×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	yellow
Type of product	End / face mill

User data

	Suitability	V_c	ISO code
Aluminium	Suitable	300 m/min	N
Aluminium (short chipping)	suitable	280 m/min	N
Alu > 10% Si	suitable only under restricted conditions	200 m/min	N
PA 66	suitable only under restricted conditions	120 m/min	N
PEEK	suitable only under restricted conditions	100 m/min	N
Cu	Suitable	80 m/min	N
CuZn	Suitable	100 m/min	N
wet maximum	suitable		
wet minimum	Suitable only under restricted conditions		
dry	Suitable only under restricted conditions		
Air	suitable only under restricted conditions		

Services

Shank grinding Type HB

129100 HB