


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

Order data

Order number	205270 18
GTIN	4062406122676
Item class	12X

Description
Version:

For roughing.

Special profile for machining non-ferrous metals.

Technical description

Tolerance nominal Ø	e8
Direction of infeed	horizontal, oblique and vertical
Flute length L_c	54 mm
Cutting edge Ø D_c	18 mm
Helix angle	45 degrees
Shank	DIN 6535 HA to h6
Overhang length L_1 incl. recess	67 mm
Overall length L	117 mm
Feed f_z for slot milling in short-chipping aluminium	0.22 mm
Recess Ø D_1	17 mm
Feed f_z for side milling in short-chipping aluminium	0.25 mm
Shank Ø D_s	18 mm
No. of teeth Z	3
Corner rounding r_v	0.32 mm

Coating	uncoated
Tool material	Solid carbide
Standard	Manufacturer's standard
Milling profile	WR
Cutting width a_e for milling operation	Full slot cutting depth $1 \times D$
Cutting width a_e for milling operation	$0.5 \times D$ for side milling
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