

Garant
Solid carbide forward / reverse corner rounding cutter, TiAlN, Radius r: 1,8mm

Order data

Order number	208172 1,8
GTIN	4062406131326
Item class	11X

Description
Version:
Extra long shank.

Double ground head **with quadrant profile.**

Tolerance: Size = **Radius r ± 0.05 mm.**

Application:

For **universal application** in virtually all materials. The newly developed coating **effectively prevents formation of built-up edges** – even in aluminium and stainless steel.

For **front** and **back deburring** of edges with contours.

Technical description

small $\varnothing D_3$	8.4 mm
No. of teeth Z	5
large $\varnothing D_2$	12 mm
$L_2 + 0.5$	6 mm
Radius r	1.8 mm
Shank $\varnothing D_s$	12 mm
Feed f_z for side milling in steel $< 900 \text{ N/mm}^2$	0.01 mm
Flute length L_c	1.8 mm
Overall length L	100 mm
$\varnothing D_1 + 0.05$	6 mm
$L_4 + 0.5$	37 mm

Radius milling	backwards and forwards
Coating	TiAlN
Tool material	Solid carbide
Standard	Manufacturer's standard
Type	N
Tolerance of radius contour	± 0.05
Cutting width a_e for milling operation	0.5 \times r for side milling
Shank	DIN 6535 HA to h6
Through-coolant	no
Shank tolerance	h6
Colour ring	green
Type of product	End mill

User data

	Suitability	V_c	ISO code
Aluminium (short chipping)	suitable	125 m/min	N
Alu > 10% Si	suitable	75 m/min	N
Steel < 500 N/mm ²	suitable	70 m/min	P
Steel < 750 N/mm ²	suitable	70 m/min	P
Steel < 900 N/mm ²	suitable	45 m/min	P
Steel < 1100 N/mm ²	suitable	40 m/min	P
INOX < 900 N/mm ²	suitable	35 m/min	M
INOX > 900 N/mm ²	suitable only under restricted conditions	30 m/min	M
GG(G)	suitable	45 m/min	K
Uni	suitable		
wet maximum	suitable		
wet minimum	suitable only under restricted conditions		

dry	suitable
Air	suitable
Services	

Shank grinding Type HB	129100 HB
------------------------	-----------