

**Garant**
**Solid carbide roughing end mill MTC, TiAlN, Ø d11 DC: 18mm**

**Order data**

Order number	205710 18
GTIN	4045197362643
Item class	11X

**Description**
**Version:**

Dimensions similar to DIN 6527.

**Optimised special knuckle profile for roughing.**

Very **high rate of metal removal.**

Can be used as a **universal end mill.**

**Application:**

Especially for **MTC (Multi Task Cutting)** use on the new generation of turning / milling centres.

**Technical description**

Feed $f_z$ for slot milling in steel $< 900 \text{ N/mm}^2$	0.1 mm
Feed $f_z$ for side milling in steel $< 900 \text{ N/mm}^2$	0.12 mm
Corner chamfer width at $45^\circ$	0.35 mm
No. of teeth Z	5
Cutting edge $\varnothing D_c$	18 mm
Shank $\varnothing D_s$	18 mm
Overall length L	80 mm
Flute length $L_c$	19 mm
Direction of infeed	horizontal, oblique and vertical
Shank	DIN 6535 HB to h6
Tolerance nominal $\varnothing$	d11

Helix angle	45 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	0.5×D for side milling
Cutting width $a_e$ for milling operation	Full slot cutting depth 1×D
Through-coolant	no
Machining strategy	MTC
Colour ring	green
Type of product	End / face mill

## User data

	Suitability	$V_c$	ISO code
Steel < 750 N/mm <sup>2</sup>	suitable	170 m/min	P
Steel < 900 N/mm <sup>2</sup>	suitable	170 m/min	P
Steel < 1100 N/mm <sup>2</sup>	suitable	140 m/min	P
Steel < 1400 N/mm <sup>2</sup>	suitable	120 m/min	P
INOX < 900 N/mm <sup>2</sup>	suitable	60 m/min	M
INOX > 900 N/mm <sup>2</sup>	suitable only under restricted conditions	50 m/min	M
Ti > 850 N/mm <sup>2</sup>	suitable	40 m/min	S
GG(G)	suitable	120 m/min	K
Uni	suitable		
wet maximum	suitable		
wet minimum	suitable only under restricted conditions		
dry	suitable only under restricted conditions		

Air

Suitable only under  
restricted conditions