

Garant
Solid carbide roughing end mill HPC, TiAlN, Ø f8 DC: 18mm

Order data

Order number	203041 18
GTIN	4045197510624
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.

Note:

NEW GENERATION AVAILABLE!

Recommended successor product is No. 203035.

Technical description

Recess Ø D ₁	17.8 mm
No. of teeth Z	4
Overhang length L ₁ incl. recess	42 mm
Cutting edge Ø D _c	18 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 Ø 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
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	250 m/min	P
Steel < 750 N/mm ²	suitable	200 m/min	P
Steel < 900 N/mm ²	suitable	180 m/min	P
Steel < 1100 N/mm ²	suitable	160 m/min	P
INOX < 900 N/mm ²	suitable	70 m/min	M
INOX > 900 N/mm ²	suitable	50 m/min	M
GG(G)	suitable	120 m/min	K
Uni	suitable		
wet maximum	suitable		

wet minimum	suitable only under restricted conditions
dry	suitable
Air	suitable