



## End mill HSS-Co8, TiAlN, Ø k10 DC: 18mm



### Order data

Order number	191590 18
GTIN	4045197103796
Item class	12W

### Description

#### Version:

Multi-flute end mill. **Eccentric relief ground.**  
Economy version.

### Technical description

Cutting edge $\varnothing D_c$	18 mm
No. of teeth Z	4
Feed $f_z$ for slot milling in steel $< 750 \text{ N/mm}^2$	0.034 mm
Shank $\varnothing D_s$	16 mm
Overall length L	92 mm
Flute length $L_c$	32 mm
Direction of infeed	horizontal, oblique and vertical
Shank	DIN 1835 B to h6
Tolerance nominal $\varnothing$	k10
Helix angle	30-40 degrees
Corner chamfer angle	90 degrees
Coating	TiAlN
Tool material	HSS Co 8
Standard	DIN 844 B

Type	N
Through-coolant	no
Colour ring	without
Type of product	End / face mill

### User data

	Suitability	V <sub>c</sub>	ISO code
Aluminium (short chipping)	suitable only under restricted conditions	120 m/min	N
Steel < 500 N/mm <sup>2</sup>	suitable	78 m/min	P
Steel < 750 N/mm <sup>2</sup>	suitable	55 m/min	P
Steel < 900 N/mm <sup>2</sup>	suitable	55 m/min	P
INOX < 900 N/mm <sup>2</sup>	suitable	17 m/min	M
INOX > 900 N/mm <sup>2</sup>	suitable only under restricted conditions	14 m/min	M
GG(G)	suitable only under restricted conditions	46 m/min	K
CuZn	suitable only under restricted conditions	92 m/min	N
Uni	suitable		
wet maximum	suitable		