

Garant

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



Order data

Order number	208170 1,8
GTIN	4045197457196
Item class	11X

Description

Version:

Extra long shank.

Double ground head **with quadrant profile.**

Tolerance: Size = Radius r ± 0.05 mm.

Application:

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

Technical description

small $\varnothing D_3$	8.4 mm
No. of teeth Z	4
Radius r	1.8 mm
large $\varnothing D_2$	12 mm
Feed f_z for side milling in steel < 900 N/mm ²	0.01 mm
$L_2 + 0.5$	6 mm
Shank $\varnothing D_s$	6 mm
Overall length L	100 mm
Flute length L_c	1.8 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	without
Type of product	End mill

User data

	Suitability	V_c	ISO code
Aluminium (short chipping)	suitable	115 m/min	N
Alu > 10% Si	suitable	70 m/min	N
Steel < 500 N/mm ²	suitable	65 m/min	P
Steel < 750 N/mm ²	suitable	65 m/min	P
Steel < 900 N/mm ²	suitable	40 m/min	P
Steel < 1100 N/mm ²	suitable	35 m/min	P
INOX < 900 N/mm ²	suitable only under restricted conditions	35 m/min	M
GG(G)	suitable	40 m/min	K
Uni	suitable only under restricted conditions		
wet maximum	suitable		
wet minimum	suitable only under restricted conditions		
dry	suitable		
Air	suitable		

