

Garant
Solid carbide milling cutter DIN 6535 HB, TiAlN, Ø e8 DC: 18mm

Order data

Order number	203480 18
GTIN	4045197119629
Item class	11X

Description
Version:

High stability and **extremely smooth cutting action**
due to at least 6 teeth.

Double relief ground clearance angle.

Application:

For peripheral milling as a **finishing operation.**

Technical description

No. of teeth Z	8
Overhang length L_1 incl. recess	42 mm
Corner chamfer width at 45°	0.05 mm
Feed f_z for side milling in steel < 900 N/mm ²	0.089 mm
Recess Ø D_1	17.8 mm
Cutting edge Ø D_c	18 mm
Shank Ø D_s	18 mm
Overall length L	92 mm
Flute length L_c	32 mm
Direction of infeed	horizontal
Shank	DIN 6535 HB to h6
Tolerance nominal Ø	e8

Helix angle	45 degrees
Corner chamfer angle	45 degrees
Coating	TiAlN
Tool material	Solid carbide
Standard	DIN 6527
Type	N
Cutting width a_e for milling operation	0.1×D for side milling
Through-coolant	no
Colour ring	green
Type of product	End / face mill

User data

	Suitability	V_c	ISO code
Aluminium (short chipping)	suitable only under restricted conditions	600 m/min	N
Alu > 10% Si	suitable only under restricted conditions	400 m/min	N
Steel < 500 N/mm ²	suitable	190 m/min	P
Steel < 750 N/mm ²	suitable	170 m/min	P
Steel < 900 N/mm ²	suitable	160 m/min	P
Steel < 1100 N/mm ²	suitable	95 m/min	P
Steel < 1400 N/mm ²	suitable	85 m/min	P
Steel < 55 HRC	suitable only under restricted conditions	65 m/min	H
INOX < 900 N/mm ²	suitable	90 m/min	M
INOX > 900 N/mm ²	suitable	75 m/min	M
Ti > 850 N/mm ²	suitable only under restricted conditions	60 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