

## Garant

### Semi-roughing end mill, TiAlN, Ø k12 DC: 18mm



## Order data

Order number	191720 18
GTIN	4045197104991
Item class	11W

## Description

### Version:

Size 10 – 30 centre cutting teeth for plunging.

or a considerable performance improvement with special ground **chip breaker flutes**.

### Advantage:

The chip breaker flutes **facilitate chip evacuation** and at the same time ensure a **good component surface finish**.

## Technical description

Cutting edge Ø D <sub>c</sub>	18 mm
Feed f <sub>z</sub> for slot milling in steel < 750 N/mm <sup>2</sup>	0.05 mm
No. of teeth Z	4
Shank Ø D <sub>s</sub>	16 mm
Overall length L	92 mm
Flute length L <sub>c</sub>	32 mm
Direction of infeed	horizontal, oblique and vertical
Shank	DIN 1835 B to h6
Tolerance nominal Ø	k12
Helix angle	27-30 degrees
Corner chamfer angle	90 degrees
Coating	TiAlN

Tool material	HSS Co 8
Standard	DIN 844 B
Milling profile	NF
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		
dry	suitable only under restricted conditions		