

Garant
Roughing end mill HSS-Co8, TiAlN, Ø k12 DC: 18mm

Order data

Order number	192605 18
GTIN	4067263290940
Item class	11W

Description
Version:

Sizes 6M to 25M – **MID mills**. Dimensions to **factory standard, between** DIN 844 **short** and DIN 844 **long**.

With relief ground knuckle profile. The wide teeth lands permit multiple re-grinding without losing the profile.

End face geometry for plunging and unequal spacing of the teeth.

Technical description

Corner chamfer angle	45 degrees
Shank	DIN 1835 B to h6
Direction of infeed	horizontal, oblique and vertical
Cutting edge Ø D _c	18 mm
Shank Ø D _s	16 mm
Flute length L _c	32 mm
Overall length L	92 mm
Helix angle	30 degrees
Feed f _z for slot milling in steel < 750 N/mm ²	0.025 mm
Tolerance nominal Ø	k12
No. of teeth Z	4
Corner chamfer width at 45°	0.5 mm

Coating	TiAlN
Tool material	HSS Co 8
Standard	DIN 844 B
Milling profile	NR
Spacing of the cutters	unequal spacing
Through-coolant	no
Colour ring	without
Type of product	End / face mill

User data

	Suitability	V _c	ISO code
Aluminium (short chipping)	suitable only under restricted conditions	120 m/min	N
Steel < 500 N/mm ²	suitable	781 m/min	P
Steel < 750 N/mm ²	suitable	55 m/min	P
Steel < 900 N/mm ²	suitable	55 m/min	P
Steel < 1100 N/mm ²	suitable	29 m/min	P
Steel < 1400 N/mm ²	suitable only under restricted conditions	25 m/min	P
INOX < 900 N/mm ²	suitable	17 m/min	M
INOX > 900 N/mm ²	suitable	14 m/min	M
GG(G)	suitable only under restricted conditions	46 m/min	K
CuZn	suitable only under restricted conditions	90 m/min	N
Uni	suitable		
wet maximum	suitable		
dry	suitable only under restricted conditions		

