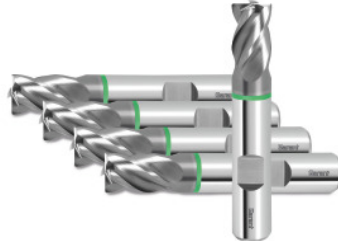


Garant**GARANT Master Steel solid carbide roughing end mill HPC, TiAlN, Ø f8 DC: 18mm****Order data**

Order number	GG1034 18
GTIN	4067263134411
Item class	GGN

Description**Version:**

Same as No. 203034.

For **roughing and finishing**.

Up to 1xD into solid material **at very high feed rates** with smooth cutting action.

At maximum machining depths, ensure compliance with the ratio dimension L_c (cutting length) / \varnothing (nominal size)!

Advantage:

Optimised flute form, eccentric relief ground, generous chip spaces.

Technical description

Corner chamfer angle	45 degrees
Feed f_z for slot milling in steel < 900 N/mm ²	0.1 mm
Shank $\varnothing D_s$	18 mm
Shank	DIN 6535 HB to h6
Helix angle	38 degrees
Tolerance nominal \varnothing	f8

Feed f_z for side milling in steel $< 900 \text{ N/mm}^2$	0.13 mm
Flute length L_c	22 mm
No. of teeth Z	4
Corner chamfer width at 45°	0.36 mm
Direction of infeed	horizontal, oblique and vertical
Cutting edge $\varnothing D_c$	18 mm
Overall length L	82 mm
Series	Master Steel
Coating	TiAlN
Tool material	Solid carbide
Standard	DIN 6527
Type	N
Helix angle characteristic	unequal spacing
Spacing of the cutters	unequal spacing
Cutting width a_e for milling operation	Full slot cutting depth $1 \times D$
Cutting width a_e for milling operation	$0.5 \times D$ for side milling
Through-coolant	no
Machining strategy	HPC
Colour ring	green
Type of product	End / face mill

User data

	Suitability	V_c	ISO code
Steel $< 500 \text{ N/mm}^2$	suitable	260 m/min	P
Steel $< 750 \text{ N/mm}^2$	suitable	240 m/min	P
Steel $< 900 \text{ N/mm}^2$	suitable	190 m/min	P
Steel $< 1100 \text{ N/mm}^2$	suitable	180 m/min	P
Steel $< 1400 \text{ N/mm}^2$	suitable only under restricted conditions	150 m/min	P

INOX < 900 N/mm ²	suitable	80 m/min	M
INOX > 900 N/mm ²	suitable	70 m/min	M
GG(G)	suitable	250 m/min	K
Uni	suitable		
wet maximum	suitable		
wet minimum	suitable only under restricted conditions		
dry	suitable		
Air	suitable		

Accessories

GARANT Master Steel solid carbide roughing end millHPC
Ø f8 DC 18 mm

203034 18