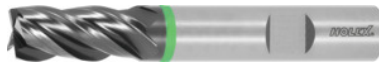



**End mill HSS-E-SPM HPC, TiAlN, Ø DC: 18mm**

**Order data**

Order number	191637 18
GTIN	4045197838971
Item class	12W

**Description**
**Version:**

Very high-performance substrate for machining steel and stainless steel materials.

**Technical description**

Overall length L	92 mm
Flute length L <sub>c</sub>	32 mm
Cutting edge Ø D <sub>c</sub>	18 mm
Feed f <sub>z</sub> for side milling in steel < 1100 N/mm <sup>2</sup>	0.07 mm
No. of teeth Z	4
Shank	DIN 1835 B to h6
Direction of infeed	horizontal, oblique and vertical
Tolerance nominal Ø	0 / -0.03
Shank Ø D <sub>s</sub>	16 mm
Helix angle	38 degrees
Corner chamfer angle	45 degrees
Coating	TiAlN
Tool material	HSS E SPM
Standard	DIN 844 B
Type	N

Helix angle characteristic	unequal spacing
Spacing of the cutters	unequal spacing
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 < 750 N/mm <sup>2</sup>	suitable	74 m/min	P
Steel < 900 N/mm <sup>2</sup>	suitable	64 m/min	P
Steel < 1100 N/mm <sup>2</sup>	suitable	42 m/min	P
Steel < 1400 N/mm <sup>2</sup>	suitable	32 m/min	P
INOX < 900 N/mm <sup>2</sup>	suitable	26 m/min	M
INOX > 900 N/mm <sup>2</sup>	suitable	21 m/min	M
Uni	suitable		
wet maximum	suitable		
dry	suitable		
Air	suitable		