


Solid carbide milling cutter, AlCrN, Ø e8 DC: 18mm

Order data

Order number	202275 18
GTIN	4045197865472
Item class	12X

Description
Version:

Dimensions similar to **DIN 6527**.

Improved coating for general-purpose applications in steel and cast iron.

Technical description

Tolerance nominal Ø	e8
Direction of infeed	horizontal, oblique and vertical
Corner chamfer width at 45°	0.4 mm
Shank Ø D _s	18 mm
Cutting edge Ø D _c	18 mm
Feed f _z for slot milling in steel < 750 N/mm ²	0.09 mm
No. of teeth Z	3
Feed f _z for side milling in steel < 750 N/mm ²	0.15 mm
Shank	DIN 6535 HB to h6
Flute length L _c	32 mm
Overall length L	92 mm
Helix angle	30 degrees
Corner chamfer angle	45 degrees
Coating	AlCrN

Tool material	Solid carbide
Standard	DIN 6527
Type	N
Cutting width a_e for milling operation	0.3×D for side milling
Cutting width a_e for milling operation	Full slot cutting depth 1×D
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	200 m/min	N
Alu > 10% Si	suitable only under restricted conditions	160 m/min	N
Steel < 500 N/mm ²	suitable	100 m/min	P
Steel < 750 N/mm ²	suitable	80 m/min	P
Steel < 900 N/mm ²	suitable	70 m/min	P
Steel < 1100 N/mm ²	suitable	50 m/min	P
INOX < 900 N/mm ²	suitable	60 m/min	M
INOX > 900 N/mm ²	suitable only under restricted conditions	40 m/min	M
GG(G)	suitable	75 m/min	K
Uni	suitable only under restricted conditions		
wet maximum	suitable		
wet minimum	suitable		
dry	suitable only under restricted conditions		
Air	suitable		

