


Solid carbide end mill, uncoated, Ø e8 DC: 18mm

Order data

Order number	202277 18
GTIN	4045197865779
Item class	12X

Description
Version:

Dimensions similar to **DIN 6527**.

Technical description

Flute length L_c	32 mm
Tolerance nominal \varnothing	e8
Corner chamfer width at 45°	0.4 mm
Feed f_z for side milling in steel < 750 N/mm ²	0.15 mm
Feed f_z for slot milling in steel < 750 N/mm ²	0.09 mm
Shank $\varnothing D_s$	18 mm
Cutting edge $\varnothing D_c$	18 mm
Direction of infeed	horizontal, oblique and vertical
No. of teeth Z	3
Overall length L	92 mm
Shank form	HB
Shank	DIN 6535 HB to h6
Helix angle	30 degrees
Corner chamfer angle	45 degrees
Coating	uncoated

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
Alu plastics	suitable only under restricted conditions	170 m/min	N
Aluminium (short chipping)	suitable	140 m/min	N
Alu > 10% Si	suitable	100 m/min	N
Steel < 500 N/mm ²	suitable	70 m/min	P
Steel < 750 N/mm ²	suitable	60 m/min	P
Steel < 900 N/mm ²	suitable	45 m/min	P
INOX < 900 N/mm ²	suitable only under restricted conditions	40 m/min	M
GG(G)	suitable only under restricted conditions	55 m/min	K
Uni	suitable only under restricted conditions		
wet maximum	suitable		
wet minimum	Suitable		
dry	Suitable only under restricted conditions		
Air	Suitable		

