

Garant
Solid carbide ball nose roughing end mill, TiAlN, Ø d11 DC: 18mm


Order data

Order number	207505 18
GTIN	4045197882783
Item class	11X

Description

Version:

Round **knuckle form profile** for roughing, **including machining radii.**

Note:

Successor product to No. 207512

Technical description

Shank Ø D _s	18 mm
Feed f _z for copy milling in steel < 900 N/mm ²	0.113 mm
Feed f _z for side milling in steel < 900 N/mm ²	0.1 mm
Flute length L _c	32 mm
Cutting edge Ø D _c	18 mm
Overall length L	92 mm
No. of teeth Z	3
Helix angle	45 degrees
Radius R	9 mm
Coating	TiAlN
Tool material	Solid carbide
Standard	DIN 6527
Milling profile	HR

Tolerance nominal \varnothing	d11
Direction of infeed	horizontal, oblique and vertical
Cutting width a_e for milling operation	0.05×D for copy milling
Cutting width a_e for milling operation	0.5×D for side milling
Shank	DIN 6535 HB to h6
Through-coolant	no
Colour ring	without
Type of product	Ball-nosed slot drill

User data

	Suitability	V_c	ISO code
Aluminium (short chipping)	suitable only under restricted conditions	350 m/min	N
Alu > 10% Si	suitable only under restricted conditions	250 m/min	N
Steel < 500 N/mm ²	suitable	160 m/min	P
Steel < 750 N/mm ²	suitable	140 m/min	P
Steel < 900 N/mm ²	suitable	130 m/min	P
Steel < 1100 N/mm ²	suitable	80 m/min	P
INOX < 900 N/mm ²	suitable	80 m/min	M
GG(G)	suitable	120 m/min	K
Uni	suitable		
wet maximum	suitable		
wet minimum	suitable only under restricted conditions		
dry	suitable only under restricted conditions		
Air	suitable only under restricted conditions		

