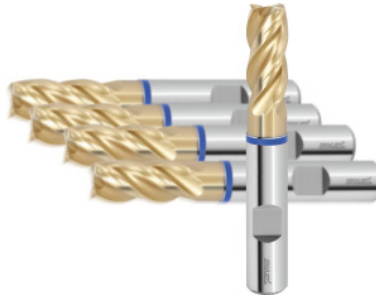



**Solid carbide milling cutter HPC, TiSi, Ø f8 DC: 18mm**

**Order data**

Order number	GG1014 18
GTIN	4045197908476
Item class	GGN

**Description**

**Version:**  
**Special TiSi coating.**  
**Same as No. 203014.**

**Technical description**

Shank	DIN 6535 HB to h6
Corner chamfer width at 45°	0.3 mm
Overall length L	92 mm
Tolerance nominal Ø	f8
Feed $f_z$ for slot milling in stainless steel > 900 N/mm <sup>2</sup>	0.07 mm
No. of teeth Z	4
Recess Ø D <sub>1</sub>	17.5 mm
Feed $f_z$ for side milling in INOX > 900 N/mm <sup>2</sup>	0.08 mm
Overhang length L <sub>1</sub> incl. recess	42 mm
Shank Ø D <sub>s</sub>	18 mm

Direction of infeed	horizontal, oblique and vertical
Flute length $L_c$	36 mm
Helix angle	35 degrees
Contents	5
Coating	TiSi
Tool material	Solid carbide
Standard	Manufacturer's standard
Type	N
Helix angle characteristic	unequal spacing
Spacing of the cutters	unequal spacing
Cutting width $a_e$ for milling operation	$0.3 \times D$ for side milling
Cutting width $a_e$ for milling operation	Full slot cutting depth $1 \times D$
Machining strategy	HPC
Colour ring	blue
Type of product	End / face mill

## User data

	Suitability	$V_c$	ISO code
Steel < 500 N/mm <sup>2</sup>	suitable	240 m/min	P
Steel < 750 N/mm <sup>2</sup>	suitable	220 m/min	P
Steel < 900 N/mm <sup>2</sup>	suitable	180 m/min	P
Steel < 1100 N/mm <sup>2</sup>	suitable	180 m/min	P
Steel < 1400 N/mm <sup>2</sup>	suitable	150 m/min	P
TOOLOX 33	suitable	115 m/min	H
TOOLOX 44	suitable	80 m/min	H
INOX < 900 N/mm <sup>2</sup>	suitable	90 m/min	M
INOX > 900 N/mm <sup>2</sup>	suitable	80 m/min	M
Uni	suitable only under restricted conditions		

wet maximum	suitable
wet minimum	suitable only under restricted conditions
dry	suitable
Air	suitable

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## Accessories

Solid carbide milling cutterHPC Ø f8 DC 18 mm

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