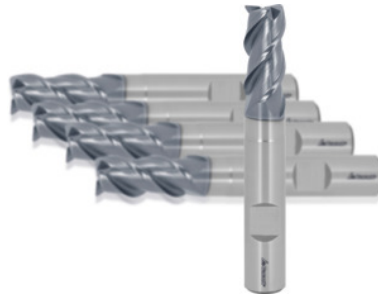


Garant
Solid carbide milling cutter, AlCrN, Ø e8 DC: 18mm

Order data

Order number	GG1294 18
GTIN	4045197907820
Item class	GGN

Description
Version:

Dimensions similar to **DIN 6527**. Improved coating for general-purpose applications in steel and cast iron.

Same as No. 202294.

Technical description

Tolerance nominal Ø	e8
Recess Ø D ₁	17.7 mm
Cutting edge Ø D _c	18 mm
No. of teeth Z	3
Flute length L _c	32 mm
Overall length L	92 mm
Corner chamfer width at 45°	0.4 mm
Feed f _z for side milling in steel < 750 N/mm ²	0.15 mm
Overhang length L ₁ incl. recess	44 mm

Shank $\varnothing D_s$	18 mm
Feed f_z for slot milling in steel $< 750 \text{ N/mm}^2$	0.09 mm
Shank form	HB
Shank	DIN 6535 HB to h6
Direction of infeed	horizontal, oblique and vertical
Helix angle	45 degrees
Corner chamfer angle	45 degrees
Contents	5
Coating	AlCrN
Tool material	Solid carbide
Standard	DIN 6527
Type	N
Cutting width a_e for milling operation	$0.5 \times D$ for side milling
Cutting width a_e for milling operation	Full slot cutting depth $1 \times D$
Type of product	End / face mill

User data

	Suitability	V_c	ISO code
Aluminium (short chipping)	suitable only under restricted conditions	280 m/min	N
Alu $> 10\% \text{ Si}$	suitable only under restricted conditions	200 m/min	N
Steel $< 500 \text{ N/mm}^2$	suitable	120 m/min	P
Steel $< 750 \text{ N/mm}^2$	suitable	110 m/min	P
Steel $< 900 \text{ N/mm}^2$	suitable	100 m/min	P
Steel $< 1100 \text{ N/mm}^2$	suitable	70 m/min	P
Steel $< 1400 \text{ N/mm}^2$	suitable only under restricted conditions	60 m/min	P
INOX $< 900 \text{ N/mm}^2$	suitable	70 m/min	M

INOX > 900 N/mm ²	suitable only under restricted conditions	50 m/min	M
GG(G)	suitable	90 m/min	K
Uni	suitable		
wet maximum	suitable		
wet minimum	suitable		
dry	Suitable only under restricted conditions		
Air	suitable		

Accessories

Solid carbide milling cutter Ø e8 DC 18 mm

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