

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

**Order data**

Order number	202285 18
GTIN	4045197931146
Item class	11X

**Description**
**Version:**

 Dimensions similar to **DIN 6527**.

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

**Technical description**

Overall length L	84 mm
Overhang length L <sub>1</sub> incl. recess	34 mm
Flute length L <sub>c</sub>	24 mm
No. of teeth Z	3
Shank form	HB
Tolerance nominal Ø	e8
Shank	DIN 6535 HB to h6
Shank Ø D <sub>s</sub>	18 mm
Cutting edge Ø D <sub>c</sub>	18 mm
Recess Ø D <sub>1</sub>	17.7 mm
Corner chamfer width at 45°	0.1 mm
Direction of infeed	horizontal, oblique and vertical
Helix angle	30 degrees
Feed f <sub>z</sub> for slot milling in steel < 750 N/mm <sup>2</sup>	0.09 mm

Feed $f_z$ for side milling in steel $< 750 \text{ N/mm}^2$	0.15 mm
Corner chamfer angle	45 degrees
Coating	AlCrN
Tool material	Solid carbide
Standard	DIN 6527
Type	N
Cutting width $a_e$ for milling operation	$0.3 \times D$ for side milling
Cutting width $a_e$ for milling operation	Full slot cutting depth $1 \times D$
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	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 $> 900 \text{ N/mm}^2$	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