

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

Order data

Order number	202825 18
GTIN	4045197948212
Item class	11X

Description
Version:

Double relief ground side clearance angle.

With **high-performance coating** for general-purpose use.

Technical description

Helix angle	35 degrees
Shank	DIN 6535 HB to h6
No. of teeth Z	4
Shank form	HB
Direction of infeed	horizontal, oblique and vertical
Tolerance nominal Ø	e8
Flute length L_c	72 mm
Shank Ø D_s	18 mm
Corner chamfer width at 45°	0.18 mm
Feed f_z for side milling in steel < 900 N/mm ²	0.1 mm
Overall length L	150 mm
Cutting edge Ø D_c	18 mm
Corner chamfer angle	45 degrees
Coating	TiAlN

Tool material	Solid carbide
Standard	Manufacturer's standard
Type	N
Cutting width a_e for milling operation	$0.1 \times D$ for side milling
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	210 m/min	N
Alu > 10% Si	suitable only under restricted conditions	140 m/min	N
Steel < 500 N/mm ²	suitable	80 m/min	P
Steel < 750 N/mm ²	suitable	75 m/min	P
Steel < 900 N/mm ²	suitable	70 m/min	P
Steel < 1100 N/mm ²	suitable	50 m/min	P
Steel < 1400 N/mm ²	suitable	40 m/min	P
Steel < 55 HRC	suitable	25 m/min	H
INOX < 900 N/mm ²	suitable	60 m/min	M
INOX > 900 N/mm ²	suitable only under restricted conditions	40 m/min	M
GG(G)	suitable	70 m/min	K
Uni	suitable only under restricted conditions		
wet maximum	suitable		
wet minimum	suitable only under restricted conditions		
dry	suitable only under restricted conditions		

Air

suitable only under
restricted conditions