

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

Order data

Order number	202640 18
GTIN	4045197117700
Item class	11X

Description
Version:

Double relief ground side clearance angle.

Technical description

Feed f_z for slot milling in steel < 900 N/mm ²	0.08 mm
Shank form	HB
Feed f_z for side milling in steel < 900 N/mm ²	0.1 mm
Overhang length L_1 incl. recess	45 mm
Recess Ø D_1	17.8 mm
Cutting edge Ø D_c	18 mm
Corner chamfer width at 45°	0.18 mm
No. of teeth Z	4
Shank Ø D_s	18 mm
Overall length L	100 mm
Flute length L_c	35 mm
Direction of infeed	horizontal, oblique and vertical
Shank	DIN 6535 HB to h6
Tolerance nominal Ø	e8
Helix angle	30 degrees

Corner chamfer angle	45 degrees
Coating	uncoated
Tool material	Solid carbide
Standard	Manufacturer's standard
Type	N
Cutting width a_e for milling operation	0.3×D for side milling
Cutting width a_e for milling operation	Full slot cutting depth 1×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	140 m/min	N
Alu > 10% Si	suitable only under restricted conditions	105 m/min	N
Steel < 500 N/mm ²	suitable	70 m/min	P
Steel < 750 N/mm ²	suitable	60 m/min	P
Steel < 900 N/mm ²	suitable	55 m/min	P
Steel < 1100 N/mm ²	suitable	35 m/min	P
Steel < 1400 N/mm ²	suitable	30 m/min	P
Steel < 55 HRC	suitable only under restricted conditions	25 m/min	H
INOX < 900 N/mm ²	suitable	40 m/min	M
INOX > 900 N/mm ²	suitable only under restricted conditions	30 m/min	M
GG(G)	suitable	55 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