

**Roughing end mill HSS-PM, TiAlN, Ø DC: 18mm****Order data**

Order number	192890 18
GTIN	4045197108715
Item class	12W

Description**Version:****Relief ground fine pitch knuckle form profile.**

Centre cutting teeth for plunging.

Economy version.

Technical description

Cutting edge Ø D _c	18 mm
Corner chamfer width at 45°	0.3 mm
No. of teeth Z	5
Feed f _z for slot milling in steel < 900 N/mm ²	0.041 mm
Shank Ø D _s	16 mm
Overall length L	92 mm
Flute length L _c	32 mm
Direction of infeed	horizontal, oblique and vertical
Shank	DIN 1835 B to h6
Tolerance nominal Ø	k12
Helix angle	30 degrees
Corner chamfer angle	45 degrees
Coating	TiAlN

Tool material	HSS PM
Standard	DIN 844
Milling profile	HR
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	138 m/min	N
Steel < 500 N/mm ²	suitable	83 m/min	P
Steel < 750 N/mm ²	suitable	64 m/min	P
Steel < 900 N/mm ²	suitable	64 m/min	P
Steel < 1100 N/mm ²	suitable	37 m/min	P
Steel < 1400 N/mm ²	suitable only under restricted conditions	32 m/min	P
INOX < 900 N/mm ²	suitable	23 m/min	M
INOX > 900 N/mm ²	suitable only under restricted conditions	18 m/min	M
CuZn	suitable only under restricted conditions	110 m/min	N
Uni	suitable		
wet maximum	suitable		
dry	suitable		