


**Solid carbide roughing end mill HPC, uncoated, Ø e8 DC: 12mm**

**Order data**

Order number	205270 12
GTIN	4062406122645
Item class	12X

**Description**
**Version:**

For roughing.

Special profile for machining non-ferrous metals.

**Technical description**

Shank	DIN 6535 HA to h6
Flute length $L_c$	36 mm
Cutting edge $\varnothing D_c$	12 mm
Overhang length $L_1$ incl. recess	46 mm
Shank $\varnothing D_s$	12 mm
Feed $f_z$ for side milling in short-chipping aluminium	0.18 mm
Overall length $L$	93 mm
Tolerance nominal $\varnothing$	e8
Helix angle	45 degrees
Direction of infeed	horizontal, oblique and vertical
Feed $f_z$ for slot milling in short-chipping aluminium	0.15 mm
Recess $\varnothing D_1$	11 mm
No. of teeth $Z$	3
Corner rounding $r_v$	0.32 mm

Coating	uncoated
Tool material	Solid carbide
Standard	Manufacturer's standard
Milling profile	WR
Cutting width $a_e$ for milling operation	Full slot cutting depth $1 \times D$
Cutting width $a_e$ for milling operation	$0.5 \times D$ for side milling
Through-coolant	no
Machining strategy	HPC
Colour ring	yellow
Type of product	End / face mill

## User data

	Suitability	$V_c$	ISO code
Aluminium	Suitable	300 m/min	N
Aluminium (short chipping)	suitable	280 m/min	N
Alu > 10% Si	suitable only under restricted conditions	200 m/min	N
PA 66	suitable only under restricted conditions	120 m/min	N
PEEK	suitable only under restricted conditions	100 m/min	N
Cu	Suitable	80 m/min	N
CuZn	Suitable	100 m/min	N
wet maximum	suitable		
wet minimum	suitable only under restricted conditions		
dry	suitable only under restricted conditions		
Air	suitable only under restricted conditions		

## Services

Shank grinding Type HB

129100 HB