


Solid carbide roughing end mill HPC, uncoated, Ø e8 DC: 20mm

Order data

Order number	205270 20
GTIN	4062406122683
Item class	12X

Description
Version:

For roughing.

Special profile for machining non-ferrous metals.

Technical description

Helix angle	45 degrees
Direction of infeed	horizontal, oblique and vertical
No. of teeth Z	3
Shank	DIN 6535 HA to h6
Tolerance nominal Ø	e8
Feed f_z for slot milling in short-chipping aluminium	0.25 mm
Flute length L_c	60 mm
Cutting edge Ø D_c	20 mm
Overall length L	126 mm
Feed f_z for side milling in short-chipping aluminium	0.28 mm
Shank Ø D_s	20 mm
Recess Ø D_1	19 mm
Overhang length L_1 incl. recess	74 mm
Corner rounding r_v	0.5 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