


Solid carbide slot drill, uncoated, Ø e8 DC: 12mm

Order data

Order number	202241 12
GTIN	4045197767066
Item class	12X

Description
Version:

Eccentric relief ground, additionally **finish ground** in the flutes for **outstanding chip evacuation** in long-chipping aluminium workpieces.

Application:

For roughing and finishing.

Technical description

Feed f_z for side milling in short-chipping aluminium	0.07 mm
Feed f_z for slot milling in short-chipping aluminium	0.05 mm
Cutting edge $\varnothing D_c$	12 mm
Shank $\varnothing D_s$	12 mm
Overall length L	83 mm
Shank	DIN 6535 HA to h6
No. of teeth Z	3
Flute length L_c	24 mm
Direction of infeed	horizontal, oblique and vertical
Tolerance nominal \varnothing	e8
Helix angle	45 degrees
Corner chamfer angle	90 degrees
Coating	uncoated

Tool material	Solid carbide
Standard	Manufacturer's standard
Type	W
Cutting width a_e for milling operation	0.5×D for side milling
Cutting width a_e for milling operation	Full slot cutting depth 1×D
Through-coolant	no
Colour ring	yellow
Type of product	End / face mill

User data

	Suitability	V_c	ISO code
Aluminium	Suitable	170 m/min	N
Aluminium (short chipping)	suitable	140 m/min	N
Alu > 10% Si	suitable	105 m/min	N
PMMA acrylic	Suitable	160 m/min	N
PE-HD	Suitable	110 m/min	N
PA 66	Suitable	130 m/min	N
PEEK	Suitable	110 m/min	N
PF 31	Suitable	90 m/min	N
Honeycomb sandwich	suitable only under restricted conditions	160 m/min	N
Cu	Suitable	120 m/min	N
CuZn	Suitable	150 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