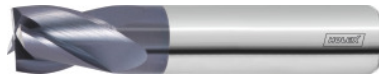



**Solid carbide milling cutter, TiAlN, Ø e8 DC: 4mm**

**Order data**

Order number	202615 4
GTIN	4062406244606
Item class	12X

**Description**
**Version:**

Eccentric relief ground.

**Note:**

Successor product to No. 202610.

**Technical description**

Shank Ø D <sub>s</sub>	4 mm
Flute length L <sub>c</sub>	8 mm
Direction of infeed	horizontal, oblique and vertical
Feed f <sub>z</sub> for side milling in steel < 900 N/mm <sup>2</sup>	0.023 mm
Overall length L	36 mm
Shank	DIN 6535 HA to h6
Cutting edge Ø D <sub>c</sub>	4 mm
No. of teeth Z	4
Shank form	HA
Tolerance nominal Ø	e8
Helix angle	30 degrees
Feed f <sub>z</sub> for slot milling in steel < 900 N/mm <sup>2</sup>	0.02 mm
Corner chamfer angle	90 degrees

Coating	TiAlN
Tool material	Solid carbide
Standard	Manufacturer's standard
Type	N
Cutting width $a_e$ for milling operation	Full slot cutting depth $1 \times D$
Cutting width $a_e$ for milling operation	$0.03 \times D$ for copy milling
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	280 m/min	N
Alu > 10% Si	suitable only under restricted conditions	200 m/min	N
Steel < 500 N/mm <sup>2</sup>	suitable	120 m/min	P
Steel < 750 N/mm <sup>2</sup>	suitable	105 m/min	P
Steel < 900 N/mm <sup>2</sup>	suitable	100 m/min	P
Steel < 1100 N/mm <sup>2</sup>	suitable	70 m/min	P
INOX < 900 N/mm <sup>2</sup>	suitable	80 m/min	M
INOX > 900 N/mm <sup>2</sup>	suitable only under restricted conditions	60 m/min	M
GG(G)	suitable	90 m/min	K
wet maximum	suitable		
wet minimum	Suitable only under restricted conditions		
dry	suitable only under restricted conditions		
Air	suitable only under restricted conditions		

