



## Solid carbide milling cutter, TiAlN, Ø DC: 12mm



### Order data

Order number	203246 12
GTIN	4062406252465
Item class	12X

### Description

#### Version:

Strengthened core and geometry for hard machining, without dynamic helical pitch. Tolerance: Size nominal Ø D<sub>c</sub> 0/-0.02 mm.

#### Application:

**For profile milling as finishing.**

(Plunge cutting only to shallow depths).

#### Note:

**Successor product to No. 203240.**

### Technical description

Cutting edge Ø D <sub>c</sub>	12 mm
Overall length L	83 mm
Helix angle	45 degrees
Tolerance nominal Ø	0 / -0.02
Direction of infeed	horizontal and oblique
Shank	DIN 6535 HA to h6
Flute length L <sub>c</sub>	26 mm
Feed f <sub>z</sub> for side milling in steel < 55 HRC	0.045 mm
Corner chamfer width at 45°	0.12 mm
Shank Ø D <sub>s</sub>	12 mm

No. of teeth Z	6
Corner chamfer angle	90 degrees
Coating	TiAlN
Tool material	Solid carbide
Standard	DIN 6527
Type	H
Cutting width $a_e$ for milling operation	$0.05 \times D$ for side milling
Through-coolant	no
Colour ring	red
Type of product	End / face mill

## User data

	Suitability	$V_c$	ISO code
Steel < 900 N/mm <sup>2</sup>	suitable	160 m/min	P
Steel < 1100 N/mm <sup>2</sup>	suitable	95 m/min	P
Steel < 1400 N/mm <sup>2</sup>	suitable	85 m/min	P
Steel < 50 HRC	suitable	75 m/min	H
Steel < 55 HRC	suitable	65 m/min	H
Steel < 60 HRC	suitable	50 m/min	H
Steel < 65 HRC	suitable only under restricted conditions	30 m/min	H
wet minimum	suitable only under restricted conditions		
dry	suitable		
Air	suitable		

## Services

Shank grinding Type HB	129100 HB
------------------------	-----------