



## Mini milling cutter HSS-PM, TiAlN, Ø e8 DC: 3,5mm



### Order data

|              |               |
|--------------|---------------|
| Order number | 191420 3,5    |
| GTIN         | 4045197102614 |
| Item class   | 12W           |

### Description

#### Version:

Centre cutting teeth for plunging.

**Eccentric relief ground.** General-purpose cutting edge geometry. Shank similar to DIN 1835 B with shank tolerance h6. For use as **slot drill or end mill** in side lock arbors and collet chucks.

**High cutting performance,** very competitive price. For milling keyways.

For the most demanding metal removal rates.

#### Note:

Save the regrinding costs: it is cheaper to use a mini slot drill to the limit of wear and throw it away, than to regrind it.

### Technical description

|  |                                  |
|--|----------------------------------|
| No. of teeth Z   | 3                                |
| Feed $f_z$ for slot milling in steel < 750 N/mm <sup>2</sup> | 0.003 mm                         |
| Cutting edge Ø D <sub>c</sub>                                | 3.5 mm                           |
| Shank Ø D <sub>s</sub>                                       | 6 mm                             |
| Overall length L   | 41 mm                            |
| Flute length L <sub>c</sub>                                  | 10 mm                            |
| Direction of infeed  | horizontal, oblique and vertical |
| Shank  | HB with h6                       |
| Tolerance nominal Ø  | e8                               |
| Helix angle  | 30 degrees                       |

|                      |                         |
|----------------------|-------------------------|
| Corner chamfer angle | 90 degrees              |
| Coating              | TiAlN                   |
| Tool material        | HSS PM                  |
| Standard             | Manufacturer's standard |
| Type                 | N                       |
| Through-coolant      | no                      |
| Colour ring          | without                 |
| Type of product      | End / face mill         |

### User data

|                                | Suitability                               | V <sub>c</sub> | ISO code |
|--------------------------------|---|----------------|----------|
| Aluminium (short chipping)     | suitable only under restricted conditions | 138 m/min      | N        |
| Alu > 10% Si                   | suitable only under restricted conditions | 110 m/min      | N        |
| Steel < 500 N/mm <sup>2</sup>  | suitable                                  | 83 m/min       | P        |
| Steel < 750 N/mm <sup>2</sup>  | suitable                                  | 64 m/min       | P        |
| Steel < 900 N/mm <sup>2</sup>  | suitable                                  | 64 m/min       | P        |
| Steel < 1100 N/mm <sup>2</sup> | suitable                                  | 37 m/min       | P        |
| Steel < 1400 N/mm <sup>2</sup> | suitable only under restricted conditions | 32 m/min       | P        |
| INOX < 900 N/mm <sup>2</sup>   | suitable                                  | 23 m/min       | M        |
| INOX > 900 N/mm <sup>2</sup>   | suitable only under restricted conditions | 18 m/min       | M        |
| CuZn                           | suitable only under restricted conditions | 110 m/min      | N        |
| Uni                            | suitable                                  |                |          |
| wet maximum                    | suitable                                  |                |          |
| dry                            | suitable                                  |                |          |

