



Mini milling cutter HSS-PM, TiAlN, Ø e8 DC: 8,5mm



Order data

Order number	191420 8,5
GTIN	4045197102713
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

Feed f_z for slot milling in steel < 750 N/mm ²	0.016 mm
Cutting edge Ø D_c	8.5 mm
No. of teeth Z	3
Shank Ø D_s	10 mm
Overall length L	56 mm
Flute length L_c	19 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 _c	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 ²	suitable	83 m/min	P
Steel < 750 N/mm ²	suitable	64 m/min	P
Steel < 900 N/mm ²	suitable	64 m/min	P
Steel < 1100 N/mm ²	suitable	37 m/min	P
Steel < 1400 N/mm ²	suitable only under restricted conditions	32 m/min	P
INOX < 900 N/mm ²	suitable	23 m/min	M
INOX > 900 N/mm ²	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		

