


Mini milling cutter HSS-PM, TiAlN, Ø e8 DC: 6,5mm

Order data

Order number	191380 6,5
GTIN	4045197102348
Item class	12W

Description
Version:

Centre cutting teeth for plunging.

Eccentric relief ground. Shank similar to DIN 1835 B with shank tolerance h6. General-purpose cutting edge geometry. 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 $< 750 \text{ N/mm}^2$	0.011 mm
Cutting edge $\varnothing D_c$	6.5 mm
Shank $\varnothing D_s$	8 mm
Overall length L	42 mm
Flute length L_c	10 mm
Direction of infeed	horizontal, oblique and vertical
Shank	HB with h6
Tolerance nominal \varnothing	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		

