


Mini milling cutter HSS-PM, TiAlN, Ø e8 DC: 4,8mm

Order data

Order number	191380 4,8
GTIN	4045197102294
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

Cutting edge Ø D _c	4.8 mm
Feed f _z for slot milling in steel < 750 N/mm ²	0.005 mm
No. of teeth Z	3
Shank Ø D _s	6 mm
Overall length L	39 mm
Flute length L _c	8 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		

