



## Roughing end mill HSS-PM, TiAlN, Ø DC: 8mm



### Order data

Order number	192890 8
GTIN	4045197108661
Item class	12W

### Description

#### Version:

#### Relief ground fine pitch knuckle form profile.

Centre cutting teeth for plunging.

Economy version.

### Technical description

Cutting edge Ø D <sub>c</sub>	8 mm
No. of teeth Z	4
Feed f <sub>z</sub> for slot milling in steel < 900 N/mm <sup>2</sup>	0.015 mm
Corner chamfer width at 45°	0.3 mm
Shank Ø D <sub>s</sub>	10 mm
Overall length L	69 mm
Flute length L <sub>c</sub>	19 mm
Direction of infeed	horizontal, oblique and vertical
Shank	DIN 1835 B to h6
Tolerance nominal Ø	k12
Helix angle	30 degrees
Corner chamfer angle	45 degrees
Coating	TiAlN

Tool material	HSS PM
Standard	DIN 844
Milling profile	HR
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
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		