



Roughing end mill HSS-Co8, TiAlN, Ø DC: 20mm



Order data

Order number	192930 20
GTIN	4045197108920
Item class	12W

Description

Version:

Relief ground fine pitch knuckle form profile.

Centre cutting teeth for plunging.

Economy version.

Technical description

No. of teeth Z	4
Cutting edge Ø D _c	20 mm
Feed f _z for side milling in steel < 900 N/mm ²	0.046 mm
Corner chamfer width at 45°	0.25 mm
Shank Ø D _s	20 mm
Overall length L	141 mm
Flute length L _c	75 mm
Direction of infeed	horizontal, oblique and vertical
Shank	DIN 1835 B to h6
Tolerance nominal Ø	js12
Helix angle	30 degrees
Corner chamfer angle	45 degrees
Coating	TiAlN
Tool material	HSS Co 8

Standard	DIN 844
Milling profile	HR
Cutting width a_e for milling operation	0.15×D for side milling
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	120 m/min	N
Alu > 10% Si	suitable only under restricted conditions	101 m/min	N
Steel < 500 N/mm ²	suitable	78 m/min	P
Steel < 750 N/mm ²	suitable	55 m/min	P
INOX < 900 N/mm ²	suitable	17 m/min	M
CuZn	suitable only under restricted conditions	92 m/min	N
Uni	suitable only under restricted conditions		
wet maximum	suitable		
dry	suitable only under restricted conditions		