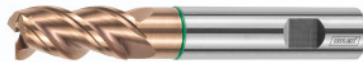



**Pro UNI solid carbide milling cutter HPC, TiSiN, Ø e8 DC: 4mm**

**Order data**

Order number	202432 4
GTIN	4062406776985
Item class	12Y

**Description**
**Version:**

For **roughing at very high feed rates** with smooth cutting action. **Innovative geometry and high-performance coating** for outstanding production results and tool life in a variety of materials. Unequal spacing gives **high intrinsic stability** and smooth cutting action.

**Technical description**

Feed $f_z$ for slot milling in steel < 900 N/mm <sup>2</sup>	0.02 mm
Corner chamfer angle	45 degrees
Overhang length $L_1$ incl. recess	17 mm
Corner chamfer width at 45°	0.08 mm
Feed $f_z$ for side milling in INOX > 900 N/mm <sup>2</sup>	0.015 mm
No. of teeth Z	3
Helix angle	42 degrees
Shank Ø $D_s$	6 mm
Recess Ø $D_1$	3.8 mm
Tolerance nominal Ø	e8
Cutting edge Ø $D_c$	4 mm
Flute length $L_c$	11 mm

Feed $f_z$ for side milling in steel $< 900 \text{ N/mm}^2$	0.025 mm
Shank	DIN 6535 HB to h6
Overall length L	57 mm
Feed $f_z$ for slot milling in stainless steel $> 900 \text{ N/mm}^2$	0.012 mm
Direction of infeed	horizontal, oblique and vertical
Series	Pro Uni
Coating	TiSiN
Tool material	Solid carbide
Standard	Manufacturer's standard
Type	N
Helix angle characteristic	unequal spacing
Spacing of the cutters	unequal spacing
Cutting width $a_e$ for milling operation	Full slot cutting depth $1 \times D$
Cutting width $a_e$ for milling operation	Full slot cutting depth $1 \times D$
Through-coolant	no
Machining strategy	HPC
Colour ring	green
Type of product	End / face mill

## User data

	Suitability	$V_c$	ISO code
Aluminium (short chipping)	Suitable only under restricted conditions		
Steel $< 500 \text{ N/mm}^2$	suitable	240 m/min	P
Steel $< 750 \text{ N/mm}^2$	suitable	220 m/min	P
Steel $< 900 \text{ N/mm}^2$	suitable	180 m/min	P
Steel $< 1100 \text{ N/mm}^2$	suitable	170 m/min	P
Steel $< 1400 \text{ N/mm}^2$	suitable		
INOX $< 900 \text{ N/mm}^2$	suitable	90 m/min	M

INOX > 900 N/mm <sup>2</sup>	suitable	80 m/min	M
Ti > 850 N/mm <sup>2</sup>	suitable only under restricted conditions		
GG(G)	suitable		
Uni	suitable		
wet maximum	suitable		
wet minimum	Suitable only under restricted conditions		
dry	suitable		
Air	suitable		