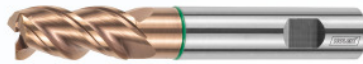




Pro UNI solid carbide milling cutter HPC, TiSiN, Ø e8 DC: 1mm



Order data

Order number	202432 1
GTIN	4062406776954
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 side milling in INOX > 900 N/mm ²	0.009 mm
Flute length L_c	2.5 mm
Overhang length L_1 incl. recess	5 mm
Overall length L	57 mm
Recess $\varnothing D_1$	0.9 mm
Helix angle	42 degrees
Direction of infeed	horizontal, oblique and vertical
No. of teeth Z	3
Shank $\varnothing D_s$	6 mm
Corner chamfer angle	45 degrees
Feed f_z for side milling in steel < 900 N/mm ²	0.012 mm
Cutting edge $\varnothing D_c$	1 mm

Tolerance nominal \varnothing	e8
Shank	DIN 6535 HB to h6
Feed f_z for slot milling in steel < 900 N/mm ²	0.009 mm
Corner chamfer width at 45°	0.06 mm
Feed f_z for slot milling in stainless steel > 900 N/mm ²	0.005 mm
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×D
Cutting width a_e for milling operation	Full slot cutting depth 1×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 N/mm ²	suitable	240 m/min	P
Steel < 750 N/mm ²	suitable	220 m/min	P
Steel < 900 N/mm ²	suitable	180 m/min	P
Steel < 1100 N/mm ²	suitable	170 m/min	P
Steel < 1400 N/mm ²	suitable		
INOX < 900 N/mm ²	suitable	90 m/min	M

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