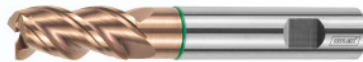




Pro UNI solid carbide milling cutter HPC, TiSiN, Ø e8 DC: 12mm



Order data

Order number	202432 12
GTIN	4062406777234
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 stainless steel $> 900 \text{ N/mm}^2$	0.04 mm
No. of teeth Z	3
Feed f_z for side milling in steel $< 900 \text{ N/mm}^2$	0.09 mm
Tolerance nominal Ø	e8
Corner chamfer angle	45 degrees
Cutting edge Ø D_c	12 mm
Feed f_z for side milling in INOX $> 900 \text{ N/mm}^2$	0.05 mm
Feed f_z for slot milling in steel $< 900 \text{ N/mm}^2$	0.07 mm
Flute length L_c	26 mm
Shank	DIN 6535 HB to h6
Shank Ø D_s	12 mm
Recess Ø D_1	11.6 mm

Corner chamfer width at 45°	0.3 mm
Helix angle	42 degrees
Direction of infeed	horizontal, oblique and vertical
Overhang length L_1 incl. recess	36 mm
Overall length L	83 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 $1 \times D$
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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		