



Solid carbide corner rounding cutter, TiSiN, Radius r: 3mm



Order data

Order number	208022 3
GTIN	4062406785925
Item class	12X

Description

Version:

Straight fluted, without profile distortion.

Tolerance: $r = \pm 0.01 \text{ mm}$.

Application:

For rounding and deburring **edges**.

Technical description

Flute length L_c	3 mm
No. of teeth Z	4
Radius r	3 mm
Feed f_z for side milling in steel $< 900 \text{ N/mm}^2$	0.025 mm
small $\varnothing D_3$	6 mm
Shank $\varnothing D_s$	12 mm
Radius milling	forwards
large $\varnothing D_2$	12 mm
Overall length L	82 mm
Coating	TiSiN
Tool material	Solid carbide

Standard	Manufacturer's standard
Type	N
Tolerance of radius contour	± 0.01
Direction of infeed	horizontal
Shank	DIN 6535 HA to h6
Through-coolant	no
Shank tolerance	h6
Colour ring	without
Type of product	corner rounding cutter, HSS-Co5

User data

	Suitability	V_c	ISO code
Alu plastics	suitable	800 m/min	N
Aluminium (short chipping)	suitable	600 m/min	N
Alu > 10% Si	suitable	400 m/min	N
Steel < 500 N/mm ²	suitable	190 m/min	P
Steel < 750 N/mm ²	suitable	170 m/min	P
Steel < 900 N/mm ²	suitable	160 m/min	P
Steel < 1100 N/mm ²	suitable	95 m/min	P
INOX < 900 N/mm ²	suitable	90 m/min	M
INOX > 900 N/mm ²	suitable	75 m/min	M
GG(G)	suitable	120 m/min	K
Uni	suitable		
wet maximum	suitable		
wet minimum	suitable only under restricted conditions		
dry	suitable only under restricted conditions		

Air

suitable only under
restricted conditions

Services

Shank grinding Type HB

129100 HB