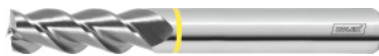



**Solid carbide milling cutter, uncoated, Ø e8 DC: 3mm**

**Order data**

Order number	202238 3
GTIN	4067263015383
Item class	12X

**Description**
**Version:**

**Eccentric relief ground**, additionally **finish ground** in the flutes for **outstanding chip evacuation** in long-chipping aluminium workpieces.

**Application:**

For roughing and finishing.

**Technical description**

Overall length L	65 mm
Direction of infeed	horizontal, oblique and vertical
Flute length $L_c$	9 mm
Helix angle	45 degrees
No. of teeth Z	3
Feed $f_z$ for side milling in short-chipping aluminium	0.01 mm
Cutting edge $\varnothing D_c$	3 mm
Corner chamfer width at 45°	0.1 mm
Feed $f_z$ for slot milling in short-chipping aluminium	0.008 mm
Shank	DIN 6535 HA to h6
Shank $\varnothing D_s$	6 mm
Corner chamfer angle	90 degrees
Tolerance nominal $\varnothing$	e8

Coating	uncoated
Tool material	Solid carbide
Standard	Works standard
Type	W
Cutting width $a_e$ for milling operation	Full slot cutting depth $1 \times D$
Cutting width $a_e$ for milling operation	$0.5 \times D$ for side milling
Through-coolant	no
Colour ring	yellow
Type of product	End / face mill

## User data

	Suitability	$V_c$	ISO code
Aluminium	suitable	170 m/min	N
Aluminium (short chipping)	suitable	140 m/min	N
Alu > 10% Si	suitable	105 m/min	N
PMMA acrylic	suitable	160 m/min	N
PE-HD	suitable	110 m/min	N
PA 66	suitable	130 m/min	N
PEEK	suitable	110 m/min	N
PF 31	suitable	90 m/min	N
Honeycomb sandwich	suitable only under restricted conditions	160 m/min	N
Cu	suitable	120 m/min	N
CuZn	suitable	150 m/min	N
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