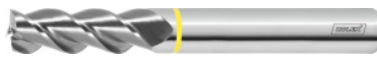



Solid carbide milling cutter, uncoated, Ø e8 DC: 4mm

Order data

Order number	202238 4
GTIN	4067263015390
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

Feed f_z for slot milling in short-chipping aluminium	0.015 mm
Overall length L	65 mm
No. of teeth Z	3
Shank Ø D_s	6 mm
Corner chamfer angle	90 degrees
Feed f_z for side milling in short-chipping aluminium	0.02 mm
Flute length L_c	12 mm
Shank	DIN 6535 HA to h6
Helix angle	45 degrees
Corner chamfer width at 45°	0.1 mm
Tolerance nominal Ø	e8
Direction of infeed	horizontal, oblique and vertical
Cutting edge Ø D_c	4 mm

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