

Solid carbide milling cutter HPC, TiAlN, Ø e8 DC: 8mm

Order data

Order number	202770 8
GTIN	4067263118671
Item class	12Z

Description

Version:

Extremely attractively priced solid carbide milling cutter for machining steels and corrosion-resistant steels. No special sizes or versions are available.

Dimensions similar to DIN 6527.

Technical description

Corner chamfer angle	45 degrees
Flute length L_c	22 mm
Feed f_z for side milling in steel $< 900 \text{ N/mm}^2$	0.055 mm
Direction of infeed	horizontal, oblique and vertical
Corner chamfer width at 45°	0.2 mm
Feed f_z for slot milling in steel $< 900 \text{ N/mm}^2$	0.045 mm
Cutting edge $\varnothing D_c$	8 mm
Shank $\varnothing D_s$	8 mm
No. of teeth Z	4
Feed f_z for side milling in INOX $> 900 \text{ N/mm}^2$	0.035 mm
Helix angle	42 degrees
Feed f_z for slot milling in stainless steel $> 900 \text{ N/mm}^2$	0.03 mm
Tolerance nominal \varnothing	e8
Shank	DIN 6535 HB to h6
Overall length L	63 mm

Coating	TiAlN
Tool material	Solid carbide
Standard	Works 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 $1 \times D$
Cutting width a_e for milling operation	$0.3 \times D$ for side milling
Through-coolant	no
Machining strategy	HPC
Type of product	End / face mill

User data

	Suitability	V_c	ISO code
Aluminium (short chipping)	suitable only under restricted conditions	230 m/min	N
Steel < 500 N/mm ²	suitable	220 m/min	P
Steel < 750 N/mm ²	suitable	200 m/min	P
Steel < 900 N/mm ²	suitable	160 m/min	P
Steel < 1100 N/mm ²	suitable	150 m/min	P
Steel < 1400 N/mm ²	suitable	120 m/min	P
INOX < 900 N/mm ²	suitable	80 m/min	M
INOX > 900 N/mm ²	suitable	70 m/min	M
Ti > 850 N/mm ²	suitable only under restricted conditions		
GG(G)	suitable	220 m/min	K
Uni	suitable		
wet maximum	suitable		
wet minimum	suitable only under restricted conditions		

dry	suitable
Air	suitable