



End mill HSS-E-SPM HPC, TiAlN, Ø DC: 20mm



Order data

Order number	191637 20
GTIN	4045197838988
Item class	12W

Description

Version:

Very high-performance substrate for machining steel and stainless steel materials.

Technical description

Shank	DIN 1835 B to h6
Tolerance nominal Ø	0 / -0.03
Feed f_z for side milling in steel < 1100 N/mm ²	0.075 mm
Cutting edge Ø D_c	20 mm
Shank Ø D_s	20 mm
Direction of infeed	horizontal, oblique and vertical
Flute length L_c	38 mm
Overall length L	104 mm
No. of teeth Z	4
Helix angle	38 degrees
Corner chamfer angle	45 degrees
Coating	TiAlN
Tool material	HSS E SPM
Standard	DIN 844 B
Type	N

Helix angle characteristic	unequal spacing
Spacing of the cutters	unequal spacing
Cutting width a_e for milling operation	$0.5 \times D$ for side milling
Through-coolant	no
Machining strategy	HPC
Colour ring	green
Type of product	End / face mill

User data

	Suitability	V_c	ISO code
Steel < 750 N/mm ²	suitable	74 m/min	P
Steel < 900 N/mm ²	suitable	64 m/min	P
Steel < 1100 N/mm ²	suitable	42 m/min	P
Steel < 1400 N/mm ²	suitable	32 m/min	P
INOX < 900 N/mm ²	suitable	26 m/min	M
INOX > 900 N/mm ²	suitable	21 m/min	M
Uni	suitable		
wet maximum	suitable		
dry	suitable		
Air	suitable		