


**Solid carbide milling cutter, AlCrN, Ø e8 DC: 4mm**

**Order data**

Order number	202275 4
GTIN	4045197865311
Item class	12X

**Description**
**Version:**

Dimensions similar to **DIN 6527**.

Improved coating for general-purpose applications in steel and cast iron.

**Technical description**

Corner chamfer width at 45°	0.18 mm
Shank Ø D <sub>s</sub>	6 mm
No. of teeth Z	3
Feed f <sub>z</sub> for side milling in steel < 750 N/mm <sup>2</sup>	0.025 mm
Direction of infeed	horizontal, oblique and vertical
Shank	DIN 6535 HB to h6
Tolerance nominal Ø	e8
Overall length L	57 mm
Flute length L <sub>c</sub>	11 mm
Feed f <sub>z</sub> for slot milling in steel < 750 N/mm <sup>2</sup>	0.02 mm
Cutting edge Ø D <sub>c</sub>	4 mm
Helix angle	30 degrees
Corner chamfer angle	45 degrees
Coating	AlCrN

Tool material	Solid carbide
Standard	DIN 6527
Type	N
Cutting width $a_e$ for milling operation	0.3×D for side milling
Cutting width $a_e$ for milling operation	Full slot cutting depth 1×D
Through-coolant	no
Colour ring	without
Type of product	End / face mill

### User data

	Suitability	$V_c$	ISO code
Aluminium (short chipping)	suitable only under restricted conditions	200 m/min	N
Alu > 10% Si	suitable only under restricted conditions	160 m/min	N
Steel < 500 N/mm <sup>2</sup>	suitable	100 m/min	P
Steel < 750 N/mm <sup>2</sup>	suitable	80 m/min	P
Steel < 900 N/mm <sup>2</sup>	suitable	70 m/min	P
Steel < 1100 N/mm <sup>2</sup>	suitable	50 m/min	P
INOX < 900 N/mm <sup>2</sup>	suitable	60 m/min	M
INOX > 900 N/mm <sup>2</sup>	suitable only under restricted conditions	40 m/min	M
GG(G)	suitable	75 m/min	K
Uni	suitable only under restricted conditions		
wet maximum	suitable		
wet minimum	suitable		
dry	suitable only under restricted conditions		
Air	suitable		

