


**Solid carbide end mill, uncoated, Ø e8 DC: 20mm**

**Order data**

Order number	202277 20
GTIN	4045197865786
Item class	12X

**Description**
**Version:**

Dimensions similar to **DIN 6527**.

**Technical description**

Flute length $L_c$	38 mm
Feed $f_z$ for side milling in steel $< 750 \text{ N/mm}^2$	0.15 mm
No. of teeth $Z$	3
Shank	DIN 6535 HB to h6
Corner chamfer width at $45^\circ$	0.5 mm
Tolerance nominal $\varnothing$	e8
Shank form	HB
Shank $\varnothing D_s$	20 mm
Overall length $L$	104 mm
Direction of infeed	horizontal, oblique and vertical
Feed $f_z$ for slot milling in steel $< 750 \text{ N/mm}^2$	0.1 mm
Cutting edge $\varnothing D_c$	20 mm
Helix angle	30 degrees
Corner chamfer angle	45 degrees
Coating	uncoated

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
Alu plastics	suitable only under restricted conditions	170 m/min	N
Aluminium (short chipping)	suitable	140 m/min	N
Alu > 10% Si	suitable	100 m/min	N
Steel < 500 N/mm <sup>2</sup>	suitable	70 m/min	P
Steel < 750 N/mm <sup>2</sup>	suitable	60 m/min	P
Steel < 900 N/mm <sup>2</sup>	suitable	45 m/min	P
INOX < 900 N/mm <sup>2</sup>	suitable only under restricted conditions	40 m/min	M
GG(G)	suitable only under restricted conditions	55 m/min	K
Uni	suitable only under restricted conditions		
wet maximum	suitable		
wet minimum	Suitable		
dry	Suitable only under restricted conditions		
Air	Suitable		

