


Solid carbide milling cutter, AlCrN, Ø e8 DC: 3,5mm

Order data

Order number	202296 3,5
GTIN	4045197866363
Item class	12X

Description
Version:

Dimensions similar to **DIN 6527**.

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

Technical description

Feed f_z for side milling in steel $< 750 \text{ N/mm}^2$	0.025 mm
Feed f_z for slot milling in steel $< 750 \text{ N/mm}^2$	0.02 mm
Shank	DIN 6535 HB to h6
Shank $\varnothing D_s$	6 mm
No. of teeth Z	3
Overall length L	57 mm
Flute length L_c	11 mm
Cutting edge $\varnothing D_c$	3.5 mm
Corner chamfer width at 45°	0.13 mm
Direction of infeed	horizontal, oblique and vertical
Shank form	HB
Tolerance nominal \varnothing	e8
Helix angle	45 degrees
Corner chamfer angle	45 degrees

Coating	AlCrN
Tool material	Solid carbide
Standard	DIN 6527
Type	N
Cutting width a_e for milling operation	0.5×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 ²	suitable	100 m/min	P
Steel < 750 N/mm ²	suitable	80 m/min	P
Steel < 900 N/mm ²	suitable	70 m/min	P
Steel < 1100 N/mm ²	suitable	50 m/min	P
INOX < 900 N/mm ²	suitable	60 m/min	M
INOX > 900 N/mm ²	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