


Solid carbide milling cutter, AlCrN, Ø e8 DC: 8,5mm

Order data

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|--------------|---------------|
| Order number | 202296 8,5 |
| GTIN | 4045197866462 |
| 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 slot milling in steel $< 750 \text{ N/mm}^2$ | 0.05 mm |
| Overall length L | 72 mm |
| Cutting edge $\varnothing D_c$ | 8.5 mm |
| Direction of infeed | horizontal, oblique and vertical |
| No. of teeth Z | 3 |
| Shank | DIN 6535 HB to h6 |
| Shank form | HB |
| Shank $\varnothing D_s$ | 10 mm |
| Corner chamfer width at 45° | 0.3 mm |
| Feed f_z for side milling in steel $< 750 \text{ N/mm}^2$ | 0.08 mm |
| Flute length L_c | 19 mm |
| Tolerance nominal \varnothing | e8 |
| Helix angle | 45 degrees |
| Corner chamfer angle | 45 degrees |

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|---|-----------------------------|
| 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