


**Solid carbide end mill, uncoated, Ø e8 DC: 1,2mm**

**Order data**

Order number	202277 1,2
GTIN	4045197880352
Item class	12X

**Description**
**Version:**

Dimensions similar to **DIN 6527**.

**Technical description**

Overall length L	50 mm
Feed $f_z$ for slot milling in steel $< 750 \text{ N/mm}^2$	0.005 mm
Flute length $L_c$	4 mm
Tolerance nominal Ø	e8
Corner chamfer width at $45^\circ$	0.1 mm
No. of teeth Z	3
Feed $f_z$ for side milling in steel $< 750 \text{ N/mm}^2$	0.006 mm
Cutting edge Ø $D_c$	1.2 mm
Shank Ø $D_s$	3 mm
Shank	DIN 6535 HA to h6
Direction of infeed	horizontal, oblique and vertical
Shank form	HA
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		

