

**Solid carbide milling cutter, uncoated, Ø e8 DC: 1,8mm****Order data**

Order number	202307 1,8
GTIN	4045197931580
Item class	12X

**Description****Version:**Dimensions similar to **DIN 6527**.**Note:****Successor product to No. 202240 / 202245.****Technical description**

Shank	DIN 6535 HA to h6
Shank form	HA
Overall length L	50 mm
Direction of infeed	horizontal, oblique and vertical
No. of teeth Z	3
Feed $f_z$ for side milling in steel $< 750 \text{ N/mm}^2$	0.006 mm
Tolerance nominal Ø	e8
Helix angle	45 degrees
Flute length $L_c$	5 mm
Shank Ø $D_s$	3 mm
Cutting edge Ø $D_c$	1.8 mm
Feed $f_z$ for slot milling in steel $< 750 \text{ N/mm}^2$	0.005 mm
Corner chamfer angle	90 degrees

Coating	uncoated
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
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		

