



## Solid carbide milling cutter, TiAlN, Ø DC: 12mm



### Order data

|              |               |
|--------------|---------------|
| Order number | 203619 12     |
| GTIN         | 4045197958907 |
| Item class   | 12X           |

### Description

#### Version:

For **finishing operations**. Special geometry for optimum chip evacuation. For **profile milling as a finishing operation**. Very sturdy version with strengthened core.

### Technical description

|   |                         |
|---|-------------------------|
| Cutting edge Ø D <sub>c</sub>   | 12 mm                   |
| Shank Ø D <sub>s</sub>  | 12 mm                   |
| No. of teeth Z  | 6                       |
| Helix angle   | 45 degrees              |
| Flute length L <sub>c</sub>   | 36 mm                   |
| Overall length L  | 93 mm                   |
| Feed f <sub>z</sub> for side milling in steel < 900 N/mm <sup>2</sup> | 0.08 mm                 |
| Tolerance nominal Ø   | h10                     |
| Shank   | DIN 6535 HA to h6       |
| Direction of infeed   | horizontal              |
| Corner chamfer angle  | 90 degrees              |
| Coating   | TiAlN                   |
| Tool material   | Solid carbide           |
| Standard  | Manufacturer's standard |

|   |                         |
|---|-------------------------|
| Type                                      | N                       |
| Cutting width $a_e$ for milling operation | 0.05×D for side milling |
| Through-coolant                           | no                      |
| Colour ring                               | without                 |
| Type of product                           | End / face mill         |

### User data

|                                | Suitability                               | $V_c$     | ISO code |
|--------------------------------|---|-----------|----------|
| Steel < 500 N/mm <sup>2</sup>  | suitable                                  | 120 m/min | P        |
| Steel < 750 N/mm <sup>2</sup>  | suitable                                  | 110 m/min | P        |
| Steel < 900 N/mm <sup>2</sup>  | suitable                                  | 100 m/min | P        |
| Steel < 1100 N/mm <sup>2</sup> | suitable                                  | 90 m/min  | P        |
| Steel < 1400 N/mm <sup>2</sup> | suitable                                  | 80 m/min  | P        |
| Steel < 55 HRC                 | suitable                                  | 60 m/min  | H        |
| Steel < 60 HRC                 | suitable                                  | 50 m/min  | H        |
| wet maximum                    | suitable                                  |           |          |
| wet minimum                    | Suitable only under restricted conditions |           |          |
| dry                            | Suitable                                  |           |          |
| Air                            | Suitable                                  |           |          |

### Services

|                        |           |
|------------------------|-----------|
| Shank grinding Type HB | 129100 HB |
|------------------------|-----------|