



Solid carbide milling cutters, uncoated, Ø e8 DC: 4mm



Order data

Order number	202239 4
GTIN	4045197964854
Item class	12X

Description

Version:

Eccentric relief ground, additionally **finish ground** in the flutes for **outstanding chip evacuation** in long-chipping aluminium workpieces.

Application:

For roughing and finishing.

Technical description

Feed f_z for side milling in short-chipping aluminium	0.02 mm
Flute length L_c	8 mm
Tolerance nominal Ø	e8
Helix angle	45 degrees
Direction of infeed	horizontal, oblique and vertical
No. of teeth Z	3
Feed f_z for slot milling in short-chipping aluminium	0.015 mm
Shank Ø D_s	6 mm
Shank	DIN 6535 HA to h6
Overall length L	65 mm
Recess Ø D_1	3.7 mm
Overhang length L_1 incl. recess	27 mm
Cutting edge Ø D_c	4 mm

Corner chamfer angle	90 degrees
Coating	uncoated
Tool material	Solid carbide
Standard	Manufacturer's standard
Type	W
Cutting width a_e for milling operation	Full slot cutting depth $1 \times D$
Cutting width a_e for milling operation	$0.5 \times D$ for side milling
Through-coolant	no
Colour ring	yellow
Type of product	End / face mill

User data

	Suitability	V_c	ISO code
Aluminium	Suitable	170 m/min	N
Aluminium (short chipping)	suitable	140 m/min	N
Alu > 10% Si	suitable	105 m/min	N
PMMA acrylic	Suitable	160 m/min	N
PE-HD	Suitable	110 m/min	N
PA 66	Suitable	130 m/min	N
PEEK	Suitable	110 m/min	N
PF 31	Suitable	90 m/min	N
Honeycomb sandwich	suitable only under restricted conditions	160 m/min	N
Cu	Suitable	120 m/min	N
CuZn	Suitable	150 m/min	N
wet maximum	suitable		
wet minimum	suitable only under restricted conditions		

dry	Suitable only under restricted conditions
Air	suitable only under restricted conditions
Services	
Shank grinding Type HB	129100 HB