



## Solid carbide milling cutters, uncoated, $\varnothing$ e8 DC: 6mm



### Order data

Order number	202239 6
GTIN	4045197964878
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

No. of teeth Z	3
Feed $f_z$ for side milling in short-chipping aluminium	0.03 mm
Helix angle	45 degrees
Recess $\varnothing D_1$	5.5 mm
Overhang length $L_1$ incl. recess	27 mm
Direction of infeed	horizontal, oblique and vertical
Flute length $L_c$	12 mm
Shank	DIN 6535 HA to h6
Shank $\varnothing D_s$	6 mm
Feed $f_z$ for slot milling in short-chipping aluminium	0.025 mm
Overall length L	65 mm
Tolerance nominal $\varnothing$	e8
Cutting edge $\varnothing D_c$	6 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
<b>Services</b>	
Shank grinding Type HB	129100 HB