



## Solid carbide milling cutters, uncoated, Ø e8 DC: 3mm



### Order data

|              |               |
|--------------|---------------|
| Order number | 202239 3      |
| GTIN         | 4045197964847 |
| 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

|  |                                  |
|--|----------------------------------|
| Recess Ø D <sub>1</sub>  | 2.7 mm                           |
| Direction of infeed  | horizontal, oblique and vertical |
| Shank Ø D <sub>s</sub>   | 6 mm                             |
| Feed f <sub>z</sub> for side milling in short-chipping aluminium | 0.01 mm                          |
| Feed f <sub>z</sub> for slot milling in short-chipping aluminium | 0.008 mm                         |
| Tolerance nominal Ø  | e8                               |
| Cutting edge Ø D <sub>c</sub>                                    | 3 mm                             |
| Overhang length L <sub>1</sub> incl. recess                      | 27 mm                            |
| Shank  | DIN 6535 HA to h6                |
| Flute length L <sub>c</sub>                                      | 6 mm                             |
| Helix angle  | 45 degrees                       |
| No. of teeth Z   | 3                                |
| Overall length L   | 65 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                                 |