



Solid carbide milling cutters, uncoated, Ø e8 DC: 10mm



Order data

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| Order number | 202239 10 |
| GTIN | 4045197964892 |
| 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.

Through-coolant: no

Tolerance nominal Ø: e8

No. of teeth Z: 3

Helix angle: 45 °

Direction of infeed: horizontal, oblique and vertical

Shank: DIN 6535 HA to h6

No. of teeth Z: 3

Flute length L_c : 20 mm

Overhang length L_1 incl. recess: 42 mm

Recess Ø D_1 : 9.5 mm

Overall length L: 85 mm

Shank Ø D_s : 10 mm

Technical description

| | |
|---|---------|
| Tolerance nominal Ø | e8 |
| Flute length L_c | 20 mm |
| Feed f_z for slot milling in short-chipping aluminium | 0.04 mm |
| Overhang length L_1 incl. recess | 42 mm |
| Feed f_z for side milling in short-chipping aluminium | 0.05 mm |

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|---|----------------------------------|
| Overall length L | 85 mm |
| Cutting edge $\varnothing D_c$ | 10 mm |
| Shank $\varnothing D_s$ | 10 mm |
| Direction of infeed | horizontal, oblique and vertical |
| Recess $\varnothing D_1$ | 9.5 mm |
| Shank | DIN 6535 HA to h6 |
| Helix angle | 45 ° |
| No. of teeth Z | 3 |
| Corner chamfer angle | 90 ° |
| Coating | uncoated |
| Tool material | Solid carbide |
| Standard | Manufacturer's standard |
| Type | W |
| Cutting width a_e for milling operation | Full slot cutting depth 1xD |
| Cutting width a_e for milling operation | 0.5xD 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