


**Solid carbide milling cutter, TiAlN, Ø DC: 4mm**

**Order data**

Order number	202545 4
GTIN	4045197117311
Item class	12X

**Description**
**Version:**
**Extra sharp cutting edges.**

Dimensions similar to DIN 6527.

Eccentric relief ground.

Through-coolant: no

Tolerance nominal Ø: e8

No. of teeth Z: 4

Helix angle: 45 °

Direction of infeed: horizontal, oblique and vertical

Shank: DIN 6535 HA to h6

No. of teeth Z: 4

Flute length  $L_c$ : 13 mm

Overall length L: 57 mm

Shank Ø  $D_s$ : 6 mm

Feed  $f_z$  for slot milling in short-chipping aluminium: 0.015 mm

Feed  $f_z$  for side milling in short-chipping aluminium: 0.025 mm

**Technical description**

Feed $f_z$ for slot milling in short-chipping aluminium	0.015 mm
No. of teeth Z	4
Feed $f_z$ for side milling in short-chipping aluminium	0.025 mm
Cutting edge Ø $D_c$	4 mm
Shank Ø $D_s$	6 mm

Overall length L	57 mm
Flute length L <sub>c</sub>	13 mm
Direction of infeed	horizontal, oblique and vertical
Shank	DIN 6535 HA to h6
Tolerance nominal Ø	e8
Helix angle	45 °
Corner chamfer angle	90 °
Coating	TiAlN
Tool material	Solid carbide
Standard	DIN 6527
Type	W
Cutting width a <sub>e</sub> for milling operation	0.25×D for side milling
Cutting width a <sub>e</sub> for milling operation	Full slot cutting depth 1×D
Through-coolant	no
Colour ring	yellow
Type of product	End / face mill

## User data

	Suitability	V <sub>c</sub>	ISO code
Aluminium	suitable	300 m/min	N
Aluminium (short chipping)	suitable	280 m/min	N
Alu > 10% Si	suitable	200 m/min	N
PMMA acrylic	Suitable	180 m/min	N
PE-HD	Suitable	130 m/min	N
PA 66	Suitable	150 m/min	N
PEEK	Suitable	130 m/min	N
PF 31	Suitable	110 m/min	N
Honeycomb sandwich	Suitable	180 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