


**Solid carbide milling cutter, uncoated, Ø e8 DC: 12mm**

**Order data**

Order number	202239 12
GTIN	4045197965004
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>	11.5 mm
No. of teeth Z	3
Flute length L <sub>c</sub>	24 mm
Direction of infeed	horizontal, oblique and vertical
Helix angle	45 degrees
Tolerance nominal Ø	e8
Shank Ø D <sub>s</sub>	12 mm
Feed f <sub>z</sub> for slot milling in short-chipping aluminium	0.05 mm
Overall length L	100 mm
Shank	DIN 6535 HA to h6
Cutting edge Ø D <sub>c</sub>	12 mm
Feed f <sub>z</sub> for side milling in short-chipping aluminium	0.07 mm
Overhang length L <sub>1</sub> incl. recess	50 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