


**Solid carbide milling cutter, TiAlN, Ø DC: 8mm**

**Order data**

Order number	203612 8
GTIN	4045197964106
Item class	12X

**Description**
**Version:**

**High stability** and **extremely smooth cutting action due to at least 6 teeth**. Eccentric relief ground. **For profile milling as a finishing operation.**

**Technical description**

Direction of infeed	horizontal
Overall length L	90 mm
Shank	DIN 6535 HA to h6
Helix angle	45 degrees
Tolerance nominal Ø	h10
Feed $f_z$ for side milling in steel $< 900 \text{ N/mm}^2$	0.063 mm
Shank Ø $D_s$	8 mm
No. of teeth Z	6
Cutting edge Ø $D_c$	8 mm
Flute length $L_c$	32 mm
Corner chamfer width at 45°	0.1 mm
Corner chamfer angle	45 degrees
Coating	TiAlN
Tool material	Solid carbide

Standard	Manufacturer's standard
Type	N
Cutting width $a_e$ for milling operation	$0.05 \times D$ for side milling
Through-coolant	no
Colour ring	without
Type of product	End / face mill

## User data

	Suitability	$V_c$	ISO code
Aluminium (short chipping)	suitable only under restricted conditions	600 m/min	N
Alu > 10% Si	suitable only under restricted conditions	400 m/min	N
Steel < 500 N/mm <sup>2</sup>	suitable	190 m/min	P
Steel < 750 N/mm <sup>2</sup>	suitable	170 m/min	P
Steel < 900 N/mm <sup>2</sup>	suitable	160 m/min	P
Steel < 1100 N/mm <sup>2</sup>	suitable	95 m/min	P
INOX < 900 N/mm <sup>2</sup>	suitable	90 m/min	M
GG(G)	suitable	120 m/min	K
Uni	suitable only under restricted conditions		
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
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