


**Solid carbide milling cutter, uncoated, Ø e8 DC: 20mm**

**Order data**

Order number	202239 20
GTIN	4045197965028
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**

Feed $f_z$ for slot milling in short-chipping aluminium	0.085 mm
Shank	DIN 6535 HA to h6
Tolerance nominal Ø	e8
Cutting edge Ø $D_c$	20 mm
Flute length $L_c$	40 mm
Overall length $L$	126 mm
Shank Ø $D_s$	20 mm
Overhang length $L_1$ incl. recess	70 mm
Helix angle	45 degrees
Recess Ø $D_1$	19.5 mm
Feed $f_z$ for side milling in short-chipping aluminium	0.12 mm
No. of teeth $Z$	3
Direction of infeed	horizontal, oblique and vertical

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