



Roughing end mill HSS-Co8, TiAlN, Ø js12 DC: 12mm



Order data

Order number	192450 12
GTIN	4045197106261
Item class	12W

Description

Version:

Relief ground knuckle form profile.

Centre cutting teeth for plunging.

Universal end mills for profile milling or for plunging.

Economy version.

Advantage:

Compared to multi-flute cutters, **better chip evacuation due to larger flutes.**

Technical description

No. of teeth Z	3
Feed f_z for slot milling in steel $< 750 \text{ N/mm}^2$	0.03 mm
Cutting edge Ø D_c	12 mm
Corner chamfer width at 45°	0.6 mm
Shank Ø D_s	12 mm
Overall length L	83 mm
Flute length L_c	26 mm
Direction of infeed	horizontal, oblique and vertical
Shank	DIN 1835 B to h6
Tolerance nominal Ø	js12
Helix angle	25 degrees

Corner chamfer angle	45 degrees
Coating	TiAlN
Tool material	HSS Co 8
Standard	DIN 844 B
Milling profile	NR
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	120 m/min	N
Steel < 500 N/mm ²	suitable	78 m/min	P
Steel < 750 N/mm ²	suitable	55 m/min	P
Steel < 900 N/mm ²	suitable	55 m/min	P
INOX < 900 N/mm ²	suitable	17 m/min	M
INOX > 900 N/mm ²	suitable only under restricted conditions	14 m/min	M
GG(G)	suitable only under restricted conditions	46 m/min	K
CuZn	suitable only under restricted conditions	92 m/min	N
Uni	suitable		
wet maximum	suitable		