


Solid carbide end mill, uncoated, Ø e8 DC: 1,8mm

Order data

Order number	202299 1,8
GTIN	4045197880109
Item class	12X

Description
Version:

Dimensions similar to **DIN 6527**.

Technical description

Flute length L_c	5 mm
Shank form	HA
Shank $\varnothing D_s$	3 mm
Overall length L	50 mm
Corner chamfer width at 45°	0.1 mm
Direction of infeed	horizontal, oblique and vertical
No. of teeth Z	3
Shank	DIN 6535 HA to h6
Cutting edge $\varnothing D_c$	1.8 mm
Feed f_z for side milling in steel $< 750 \text{ N/mm}^2$	0.006 mm
Feed f_z for slot milling in steel $< 750 \text{ N/mm}^2$	0.005 mm
Tolerance nominal \varnothing	e8
Helix angle	45 degrees
Corner chamfer angle	45 degrees

Coating	uncoated
Tool material	Solid carbide
Standard	DIN 6527
Type	N
Cutting width a_e for milling operation	0.5×D for side milling
Cutting width a_e for milling operation	Full slot cutting depth 1×D
Through-coolant	no
Colour ring	without
Type of product	End / face mill

User data

	Suitability	V_c	ISO code
Alu plastics	suitable only under restricted conditions	170 m/min	N
Aluminium (short chipping)	suitable	140 m/min	N
Alu > 10% Si	suitable	100 m/min	N
Steel < 500 N/mm ²	suitable	70 m/min	P
Steel < 750 N/mm ²	suitable	60 m/min	P
Steel < 900 N/mm ²	suitable	45 m/min	P
INOX < 900 N/mm ²	suitable only under restricted conditions	40 m/min	M
GG(G)	suitable only under restricted conditions	55 m/min	K
Uni	suitable only under restricted conditions		
wet maximum	suitable		
wet minimum	Suitable		
dry	suitable only under restricted conditions		
Air	Suitable		

