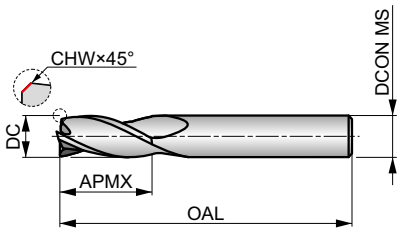
S823

DORMER

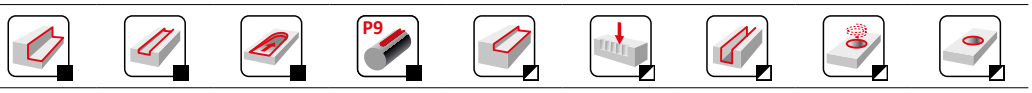


3-Flute Solid Carbide Slot End Mill

Medium cut length, 3-flute design provides high rigidity for milling standard slots to a P9 tolerance and ramping operation. AlCrN coating improves performance and extends the tool life.



HM	N	NOF 3
	λ 28°	γ 9°
DIN 6535HA	AlCrN	
DORMER		



Workpiece material group suitability, starting values for cutting speed (m/min) and Alpha Code. Tables with feed per tooth and correction factors can be found starting from page 112.

P1.1	P1.2	P1.3	P2.1	P2.2	P2.3	P3.1	P3.2	P3.3	P4.1	P4.2	P4.3	M1.1	M1.2
■145 J	■162 J	■167 J	■124 J	■109 J	■97 I	■100 J	■81 I	■68 I	■60 I	■51 I	◪41 I	■84 J	■71 J
M2.1	**M2.2**	**M3.1**	**M3.2**	**M3.3**	**M4.1**	**K1.1**	**K1.2**	**K1.3**	**K2.1**	**K2.2**	**K2.3**	**K3.1**	**K3.2**
■75 J	■61 I	◪69 I	◪59 I	◪53 I	◪52 I	■144 J	■107 J	■80 J	■149 J	■121 J	■96 I	■132 J	■101 J
K3.3	**K4.1**	**K4.2**	**K4.3**	**K4.4**	**K4.5**	**K5.1**	**K5.2**	**K5.3**	**N1.1**	**N1.2**	**N1.3**	**N2.1**	**N2.2**
■81 I	■122 I	■92 I	■67 I	■58 I	■48 I	■138 I	■104 I	■80 I	◪284 K	◪214 K	■143 K	■143 J	■128 J
N2.3	**N3.1**	**N3.2**	**N3.3**	**N4.1**	**N4.2**	**S1.1**	**S1.2**	**S2.1**	**S3.1**	**S4.1**			
■92 J	■150 J	■87 J	◪45 J	◪150 J	◪58 J	◪113 I	◪100 I	◪77 I	◪58 I	◪45 I			

DCON MS tolerance h6; DC≤7.00 mm: CHW ± 0.03X45° mm; DC>7.00 mm: CHW ± 0.05X45° mm.

Product	DC [mm]	CHW [mm]	DCON MS [mm]	APMX [mm]	OAL [mm]	NOF
S8232.0	2.00	–	6.00	8.00	57.0	3
S8232.5	2.50	0.08	6.00	12.00	57.0	3
S8233.0	3.00	0.08	6.00	12.00	57.0	3
S8234.0	4.00	0.13	6.00	14.00	57.0	3
S8235.0	5.00	0.13	6.00	16.00	57.0	3
S8236.0	6.00	0.13	6.00	19.00	57.0	3
S8237.0	7.00	0.13	8.00	19.00	63.0	3
S8238.0	8.00	0.20	8.00	19.00	63.0	3
S8239.0	9.00	0.20	10.00	21.00	72.0	3
S82310.0	10.00	0.20	10.00	22.00	72.0	3
S82312.0	12.00	0.20	12.00	25.00	83.0	3
S82314.0	14.00	0.20	14.00	30.00	83.0	3
S82316.0	16.00	0.20	16.00	32.00	92.0	3
S82318.0	18.00	0.20	18.00	32.00	92.0	3
S82320.0	20.00	0.30	20.00	38.00	104.0	3