


Solid carbide milling cutter HPC, TiSi, Ø f8 DC: 4mm

Order data

Order number	203014 4
GTIN	4045197550972
Item class	12X

Description
Version:
Special TiSi coating.
Note:
NEW GENERATION AVAILABLE!
Recommended successor products are No. 203013, 203015, 203021, 203027.

Tolerance nominal Ø: f8

No. of teeth Z: 4

Helix angle: 35 °

Direction of infeed: horizontal, oblique and vertical

Shank: DIN 6535 HB to h6

No. of teeth Z: 4

Flute length L_c: 11 mm

Overhang length L₁ incl. recess: 17 mm

Recess Ø D₁: 3.8 mm

Overall length L: 57 mm

Shank Ø D_s: 6 mm

Technical description

Overhang length L ₁ incl. recess	17 mm
Corner chamfer width at 45°	0.1 mm
Cutting edge Ø D _c	4 mm
Feed f _z for side milling in INOX > 900 N/mm ²	0.015 mm
Recess Ø D ₁	3.8 mm

Feed f_z for slot milling in stainless steel $> 900 \text{ N/mm}^2$	0.012 mm
No. of teeth Z	4
Shank $\varnothing D_s$	6 mm
Overall length L	57 mm
Flute length L_c	11 mm
Direction of infeed	horizontal, oblique and vertical
Shank	DIN 6535 HB to h6
Tolerance nominal \varnothing	f8
Helix angle	35°
Corner chamfer angle	45°
Coating	TiSi
Tool material	Solid carbide
Standard	Manufacturer's standard
Type	N
Helix angle characteristic	unequal spacing
Spacing of the cutters	unequal spacing
Cutting width a_e for milling operation	$0.3 \times D$ for side milling
Cutting width a_e for milling operation	Full slot cutting depth $1 \times D$
Through-coolant	no
Machining strategy	HPC
Colour ring	blue
Type of product	End / face mill

User data

	Suitability	V_c	ISO code
Steel $< 500 \text{ N/mm}^2$	suitable	240 m/min	P
Steel $< 750 \text{ N/mm}^2$	suitable	220 m/min	P
Steel $< 900 \text{ N/mm}^2$	suitable	180 m/min	P
Steel $< 1100 \text{ N/mm}^2$	suitable	180 m/min	P

Steel < 1400 N/mm ²	suitable	150 m/min	P
TOOLOX 33	suitable	115 m/min	H
TOOLOX 44	suitable	80 m/min	H
INOX < 900 N/mm ²	suitable	90 m/min	M
INOX > 900 N/mm ²	suitable	80 m/min	M
Uni	suitable only under restricted conditions		
wet maximum	suitable		
wet minimum	suitable only under restricted conditions		
dry	suitable		
Air	Suitable		