



## Solid carbide milling cutter with internal coolant supply HPC, TiSi, Ø f8 DC: 6mm



### Order data

Order number	203017 6
GTIN	4045197591524
Item class	12X

### Description

#### Version:

#### Special TiSi coating.

With **internal coolant supply** for reliable chip evacuation.

#### 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  $L_c$ : 13 mm

Overhang length  $L_1$  incl. recess: 19 mm

Recess Ø  $D_1$ : 5.8 mm

Overall length L: 57 mm

Shank Ø  $D_s$ : 6 mm

### Technical description

Cutting edge Ø $D_c$	6 mm
Recess Ø $D_1$	5.8 mm
Feed $f_z$ for side milling in INOX > 900 N/mm <sup>2</sup>	0.03 mm
No. of teeth Z	4

Overhang length $L_1$ incl. recess	19 mm
Feed $f_z$ for slot milling in stainless steel $> 900 \text{ N/mm}^2$	0.025 mm
Corner chamfer width at $45^\circ$	0.1 mm
Shank $\varnothing D_s$	6 mm
Overall length L	57 mm
Flute length $L_c$	13 mm
Direction of infeed	horizontal, oblique and vertical
Shank	DIN 6535 HB to h6
Tolerance nominal $\varnothing$	f8
Helix angle	$35^\circ$
Corner chamfer angle	$45^\circ$
Coating	TiSi
Tool material	Solid carbide
Standard	DIN 6527
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	yes
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 N/mm <sup>2</sup>	suitable	180 m/min	P
Steel < 1400 N/mm <sup>2</sup>	suitable	150 m/min	P
TOOLOX 33	suitable	115 m/min	H
TOOLOX 44	suitable	80 m/min	H
INOX < 900 N/mm <sup>2</sup>	suitable	90 m/min	M
INOX > 900 N/mm <sup>2</sup>	suitable	80 m/min	M
Uni	suitable only under restricted conditions		
wet maximum	suitable		
<del>Air</del>	<del>Suitable</del>		
<b>Services</b>			

Shank recess Type FRST

209900 FRST