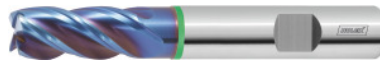




## Solid carbide roughing end mill HPC, TiXSi, Ø f8 DC: 14mm



### Order data

Order number	203044 14
GTIN	4045197679406
Item class	12X

### Description

#### Version:

For **roughing and finishing**.

Up to 1.5×D into solid material **at very high feed rates** with smooth cutting action.

#### Advantage:

Optimised flute form, eccentric relief ground, wide chip space.

Tolerance nominal Ø: f8

No. of teeth Z: 4

Helix angle: 38 °

Direction of infeed: horizontal, oblique and vertical

Shank: DIN 6535 HB to h6

No. of teeth Z: 4

Flute length  $L_c$ : 26 mm

Overhang length  $L_1$  incl. recess: 36 mm

Recess Ø  $D_1$ : 13.6 mm

Overall length L: 83 mm

Shank Ø  $D_s$ : 14 mm

### Technical description

No. of teeth Z	4
Corner chamfer width at 45°	0.3 mm
Feed $f_z$ for side milling in steel < 900 N/mm <sup>2</sup>	0.1 mm
Overhang length $L_1$ incl. recess	36 mm
Feed $f_z$ for slot milling in steel < 900 N/mm <sup>2</sup>	0.08 mm

Cutting edge $\varnothing D_c$	14 mm
Recess $\varnothing D_1$	13.6 mm
Shank $\varnothing D_s$	14 mm
Overall length L	83 mm
Flute length $L_c$	26 mm
Direction of infeed	horizontal, oblique and vertical
Shank	DIN 6535 HB to h6
Tolerance nominal $\varnothing$	f8
Helix angle	38 °
Corner chamfer angle	45 °
Coating	TiXSi
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×D for side milling
Cutting width $a_e$ for milling operation	Full slot cutting depth 1×D
Through-coolant	no
Machining strategy	HPC
Colour ring	green
Type of product	End / face mill

## User data

	Suitability	$V_c$	ISO code
Steel < 500 N/mm <sup>2</sup>	suitable	250 m/min	P
Steel < 750 N/mm <sup>2</sup>	suitable	200 m/min	P
Steel < 900 N/mm <sup>2</sup>	suitable	180 m/min	P
Steel < 1100 N/mm <sup>2</sup>	suitable	160 m/min	P

INOX < 900 N/mm <sup>2</sup>	suitable only under restricted conditions	70 m/min	M
GG(G)	suitable only under restricted conditions	120 m/min	K
Uni	suitable		
wet maximum	suitable		
wet minimum	suitable only under restricted conditions		
dry	suitable		
Air	suitable		
<b>Services</b>			

Shank recess Type FRST

209900 FRST