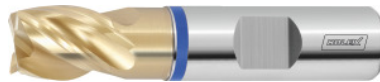



**Solid carbide milling cutter HPC, TiSi, Ø f8 DC: 3mm**

**Order data**

Order number	202995 3
GTIN	4045197494009
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  $L_c$ : 5 mm

Overall length L: 50 mm

Shank Ø  $D_s$ : 6 mm

Corner chamfer width at 45°: 0.1 mm

Feed  $f_z$  for slot milling in stainless steel > 900 N/mm<sup>2</sup>: 0.012 mm

**Technical description**

No. of teeth Z	4
Cutting edge Ø $D_c$	3 mm
Feed $f_z$ for side milling in INOX > 900 N/mm <sup>2</sup>	0.015 mm
Feed $f_z$ for slot milling in stainless steel > 900 N/mm <sup>2</sup>	0.012 mm
Corner chamfer width at 45°	0.1 mm

Shank $\varnothing D_s$	6 mm
Overall length L	50 mm
Flute length $L_c$	5 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	DIN 6527
Type	N
Helix angle characteristic	unequal spacing
Spacing of the cutters	unequal spacing
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
Machining strategy	HPC
Colour ring	blue
Type of product	End / face mill

## User data

	Suitability	$V_c$	ISO code
Steel < 500 N/mm <sup>2</sup>	suitable	240 m/min	P
Steel < 750 N/mm <sup>2</sup>	suitable	220 m/min	P
Steel < 900 N/mm <sup>2</sup>	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		
wet minimum	suitable only under restricted conditions		
dry	suitable		
Air	suitable		