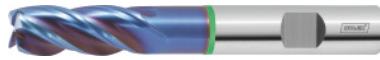




Solid carbide roughing end mill HPC, TiXSi, Ø DC: 8mm



Order data

| | |
|--------------|---------------|
| Order number | 203047 8 |
| GTIN | 4045197679468 |
| Item class | 12X |

Description

Version:

For **roughing and finishing**.

Up to $0.7 \times D$ into solid material **at very high feed rates** with smooth cutting action.

Without dynamic twist pitch.

Advantage:

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

Tolerance nominal \varnothing : 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 : 24 mm

Overhang length L_1 incl. recess: 30 mm

Recess $\varnothing D_1$: 7.7 mm

Overall length L: 68 mm

Shank $\varnothing D_s$: 8 mm

Technical description

| | |
|---|---------|
| Feed f_z for slot milling in steel $< 900 \text{ N/mm}^2$ | 0.05 mm |
| Overhang length L_1 incl. recess | 30 mm |
| Feed f_z for side milling in steel $< 900 \text{ N/mm}^2$ | 0.06 mm |
| Recess $\varnothing D_1$ | 7.7 mm |
| No. of teeth Z | 4 |

| | |
|---|----------------------------------|
| Corner chamfer width at 45° | 0.2 mm |
| Cutting edge $\varnothing D_c$ | 8 mm |
| Shank $\varnothing D_s$ | 8 mm |
| Overall length L | 68 mm |
| Flute length L_c | 24 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 | Manufacturer's standard |
| Type | N |
| Spacing of the cutters | unequal spacing |
| Cutting width a_e for milling operation | 0.25×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 ² | suitable | 250 m/min | P |
| Steel < 750 N/mm ² | suitable | 200 m/min | P |
| Steel < 900 N/mm ² | suitable | 180 m/min | P |
| Steel < 1100 N/mm ² | suitable | 160 m/min | P |

| | | | |
|------------------------------|---|-----------|---|
| INOX < 900 N/mm ² | 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 | | |
| Services | | | |

Shank recess Type FRST

209900 FRST