HOLEX

Solid carbide milling cutter with chip separators TPC, TiAlN, ⌀ f8 DC: 4mm

Order data

Order number	203095 4
GTIN	4062406117313
Item class	12X

Description

Version:
High-performance end mill for general-purpose applications, **specially designed for TPC applications**.
Strengthened core.
Optimised bending strength due to the use of ultra-fine grain substrates.
Offset chip breakers for controlled chip breaking.
Note:
h_{max}: The values stated in the table are maximum values. For finishing operations we recommend items No. 204012, 204014 and 204015.
$a_{e\,max}$ = 0.07×D for TPC machining.

Technical description

Helix angle	40 degrees
Tolerance nominal ⌀	f8
Balance quality with shank	G 2.5 with HB
Cutting edge ⌀ D_C	4 mm
Average chip thickness h_{max} for TPC milling in Toolox 44 HRC	0.018 mm
Overhang length L_1 incl. recess	23 mm
Flute length L_c	16 mm
Direction of infeed	horizontal and oblique
Corner chamfer width at 45°	0.08 mm

Shank ∅ D_s	6 mm
No. of teeth Z	5
Shank	DIN 6535 HB to h6
Recess ∅ D_1	3.9 mm
Overall length L	62 mm
Corner chamfer angle	45 degrees
Number of chip separators	1
Coating	TiAlN
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	0.07×D
Through-coolant	no
Machining strategy	TPC
Colour ring	green
Type of product	End / face mill

User data

	Suitability	V_c	ISO code
Steel < 500 N/mm²	suitable	380 m/min	P
Steel < 750 N/mm²	suitable	340 m/min	P
Steel < 900 N/mm²	suitable	300 m/min	P
Steel < 1100 N/mm²	suitable	230 m/min	P
Steel < 1400 N/mm²	suitable	150 m/min	P
TOOLOX 33	suitable	60 m/min	H
TOOLOX 44	suitable	40 m/min	H

HARDOX 500 < 1600 N/mm²	suitable	25 m/min	H
INOX < 900 N/mm²	suitable	220 m/min	M
INOX > 900 N/mm²	Suitable only under restricted conditions	150 m/min	M
Uni	Suitable		
wet maximum	suitable		
dry	suitable only under restricted conditions		
Air	suitable		