


Solid carbide milling cutter HPC, TiSi, Ø f8 DC: 20mm

Order data

Order number	GG1014 20
GTIN	4045197735645
Item class	GGN

Description

Version:
Special TiSi coating.
Same as No. 203014.

Technical description

Shank	DIN 6535 HB to h6
Flute length L_c	41 mm
Feed f_z for side milling in INOX > 900 N/mm ²	0.08 mm
Overhang length L_1 incl. recess	52 mm
No. of teeth Z	4
Cutting edge $\varnothing D_c$	20 mm
Corner chamfer width at 45°	0.3 mm
Direction of infeed	horizontal, oblique and vertical
Shank $\varnothing D_s$	20 mm
Recess $\varnothing D_1$	19.5 mm

Tolerance nominal \varnothing	f8
Overall length L	104 mm
Feed f_z for slot milling in stainless steel $> 900 \text{ N/mm}^2$	0.07 mm
Helix angle	35 degrees
Contents	5
Coating	TiSi
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	$0.3 \times D$ for side milling
Cutting width a_e for milling operation	Full slot cutting depth $1 \times D$
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 $< 1100 \text{ N/mm}^2$	suitable	180 m/min	P
Steel $< 1400 \text{ N/mm}^2$	suitable	150 m/min	P
TOOLOX 33	suitable	115 m/min	H
TOOLOX 44	suitable	80 m/min	H
INOX $< 900 \text{ N/mm}^2$	suitable	90 m/min	M
INOX $> 900 \text{ N/mm}^2$	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

Accessories

Solid carbide milling cutterHPC Ø f8 DC 20 mm

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