


**Solid carbide milling cutter HPC, TiSi, Ø f8 DC: 14mm**

**Order data**

Order number	203014 14
GTIN	4045197746573
Item class	12X

**Description**
**Version:**
**Special TiSi coating.**
**Note:**
**NEW GENERATION AVAILABLE!**
**Recommended successor products are No. 203013, 203015, 203021, 203027.**
**Technical description**

Direction of infeed	horizontal, oblique and vertical
Recess Ø D <sub>1</sub>	13.6 mm
Overall length L	83 mm
Feed f <sub>z</sub> for slot milling in stainless steel > 900 N/mm <sup>2</sup>	0.04 mm
Tolerance nominal Ø	f8
No. of teeth Z	4
Shank Ø D <sub>s</sub>	14 mm
Feed f <sub>z</sub> for side milling in INOX > 900 N/mm <sup>2</sup>	0.05 mm
Flute length L <sub>c</sub>	26 mm
Cutting edge Ø D <sub>c</sub>	14 mm
Overhang length L <sub>1</sub> incl. recess	36 mm
Shank	DIN 6535 HB to h6
Corner chamfer width at 45°	0.3 mm

Helix angle	35 degrees
Corner chamfer angle	45 degrees
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×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