



Solid carbide milling cutter HPC, TiSi, Ø f8 DC: 18mm



Order data

Order number	203014 18
GTIN	4045197746580
Item class	12X

Description

Version:

Special TiSi coating.

Note:

NEW GENERATION AVAILABLE!

Recommended successor products are No. 203013, 203015, 203021, 203027.

Technical description

No. of teeth Z	4
Direction of infeed	horizontal, oblique and vertical
Feed f_z for slot milling in stainless steel $> 900 \text{ N/mm}^2$	0.07 mm
Overhang length L_1 incl. recess	42 mm
Flute length L_c	36 mm
Overall length L	104 mm
Shank	DIN 6535 HB to h6
Feed f_z for side milling in INOX $> 900 \text{ N/mm}^2$	0.08 mm
Cutting edge $\varnothing D_c$	18 mm
Corner chamfer width at 45°	0.3 mm
Recess $\varnothing D_1$	17.5 mm
Shank $\varnothing D_s$	18 mm
Tolerance nominal \varnothing	f8

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	$0.3 \times D$ for side milling
Cutting width a_e for milling operation	Full slot cutting depth $1 \times D$
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 ²	suitable	240 m/min	P
Steel < 750 N/mm ²	suitable	220 m/min	P
Steel < 900 N/mm ²	suitable	180 m/min	P
Steel < 1100 N/mm ²	suitable	180 m/min	P
Steel < 1400 N/mm ²	suitable	150 m/min	P
TOOLOX 33	suitable	115 m/min	H
TOOLOX 44	suitable	80 m/min	H
INOX < 900 N/mm ²	suitable	90 m/min	M
INOX > 900 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