Data sheet

# Solid carbide milling cutter with chip separators TPC, TiAlN, Ø f8 DC: 16mm

## Order data

| | |
|---|---|
| Order number | 203101 16 |
| GTIN | 4062406252564 |
| Item class | 12X |

## Description

**Version:**
High-performance milling cutter with **irregular cutter spacing** and **irregular helical pitch.** Optimised bending strength due to the use of ultra-fine grain substrates. **Chip breakers for controlled chip breaking.**
**Note:**
$h_{max}$: The values stated in the table are maximum values.
$a_{e\ max}$= 0.07×D for TPC machining.

## Technical description

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|---|---|
| Overall length L | 108 mm |
| Corner chamfer width at 45° | 0.32 mm |
| Balance quality with shank | G 2.5 with HB |
| Flute length $L_c$ | 48 mm |
| Overhang length $L_1$ incl. recess | 55 mm |
| Recess Ø $D_1$ | 15.8 mm |
| Shank Ø $D_s$ | 16 mm |
| Direction of infeed | horizontal and oblique |
| Tolerance nominal Ø | f8 |
| Shank | DIN 6535 HB to h6 |
| Helix angle | 40 degrees |

# Data sheet

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|---|---|
| No. of teeth Z | 5 |
| Average chip thickness $h_{max}$ for TPC milling in INOX < 900 N/mm$^2$ | 0.078 mm |
| Cutting edge ∅ $D_C$ | 16 mm |
| Corner chamfer angle | 45 degrees |
| 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 | blue |
| Type of product | End / face mill |

## User data

| | **Suitability** | **$V_c$** | **ISO code** |
|---|---|---|---|
| Steel < 500 N/mm$^2$ | suitable | 380 m/min | P |
| Steel < 750 N/mm$^2$ | suitable | 340 m/min | P |
| Steel < 900 N/mm$^2$ | suitable | 300 m/min | P |
| Steel < 1100 N/mm$^2$ | suitable | 230 m/min | P |
| INOX < 900 N/mm$^2$ | suitable | 240 m/min | M |
| INOX > 900 N/mm$^2$ | suitable | 170 m/min | M |
| wet maximum | Suitable | | |
| wet minimum | Suitable only under restricted conditions | | |
| Air | suitable | | |