



Solid carbide milling cutter, TiAlN, Ø DC: 20mm



Order data

Order number	203246 20
GTIN	4062406252496
Item class	12X

Description

Version:

Strengthened core and geometry for hard machining, without dynamic helical pitch. Tolerance: Size nominal Ø D_c 0/-0.02 mm.

Application:

For profile milling as finishing.

(Plunge cutting only to shallow depths).

Note:

Successor product to No. 203240.

Technical description

Helix angle	45 degrees
Direction of infeed	horizontal and oblique
Cutting edge Ø D _c	20 mm
Tolerance nominal Ø	0 / -0.02
Corner chamfer width at 45°	0.2 mm
Feed f _z for side milling in steel < 55 HRC	0.055 mm
Shank Ø D _s	20 mm
Shank	DIN 6535 HA to h6
Overall length L	104 mm
Flute length L _c	38 mm

No. of teeth Z	6
Corner chamfer angle	90 degrees
Coating	TiAlN
Tool material	Solid carbide
Standard	DIN 6527
Type	H
Cutting width a_e for milling operation	0.05×D for side milling
Through-coolant	no
Colour ring	red
Type of product	End / face mill

User data

	Suitability	V_c	ISO code
Steel < 900 N/mm ²	suitable	160 m/min	P
Steel < 1100 N/mm ²	suitable	95 m/min	P
Steel < 1400 N/mm ²	suitable	85 m/min	P
Steel < 50 HRC	suitable	75 m/min	H
Steel < 55 HRC	suitable	65 m/min	H
Steel < 60 HRC	suitable	50 m/min	H
Steel < 65 HRC	suitable only under restricted conditions	30 m/min	H
wet minimum	suitable only under restricted conditions		
dry	suitable		
Air	suitable		

Services

Shank grinding Type HB	129100 HB
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