


**Solid carbide milling cutter HPC, TiSi, Ø f8 DC: 4mm**

**Order data**

Order number	203014 4
GTIN	4045197550972
Item class	12X

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

Overhang length $L_1$ incl. recess	17 mm
Corner chamfer width at 45°	0.1 mm
Cutting edge $\varnothing D_c$	4 mm
Feed $f_z$ for side milling in INOX > 900 N/mm <sup>2</sup>	0.015 mm
Recess $\varnothing D_1$	3.8 mm
Feed $f_z$ for slot milling in stainless steel > 900 N/mm <sup>2</sup>	0.012 mm
No. of teeth Z	4
Shank $\varnothing D_s$	6 mm
Overall length L	57 mm
Flute length $L_c$	11 mm
Direction of infeed	horizontal, oblique and vertical
Shank	DIN 6535 HB to h6
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 <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