


Solid carbide milling cutter HPC, TiSi, Ø f8 DC: 20mm

Order data

Order number	203014 20
GTIN	4045197551047
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	52 mm
Recess $\varnothing D_1$	19.5 mm
Cutting edge $\varnothing D_c$	20 mm
Feed f_z for side milling in INOX > 900 N/mm ²	0.08 mm
No. of teeth Z	4
Corner chamfer width at 45°	0.3 mm
Feed f_z for slot milling in stainless steel > 900 N/mm ²	0.07 mm
Shank $\varnothing D_s$	20 mm
Overall length L	104 mm
Flute length L_c	41 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×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 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