



Solid carbide milling cutter with internal coolant supply HPC, TiSi, Ø f8 DC: 8mm



Order data

Order number	203017 8
GTIN	4045197591531
Item class	12X

Description

Version:

Special TiSi coating.

With **internal coolant supply** for reliable chip evacuation.

Note:

NEW GENERATION AVAILABLE!

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

Technical description

Feed f_z for slot milling in stainless steel $> 900 \text{ N/mm}^2$	0.025 mm
Corner chamfer width at 45°	0.2 mm
Feed f_z for side milling in INOX $> 900 \text{ N/mm}^2$	0.04 mm
No. of teeth Z	4
Overhang length L_1 incl. recess	25 mm
Cutting edge $\varnothing D_c$	8 mm
Recess $\varnothing D_1$	7.7 mm
Shank $\varnothing D_s$	8 mm
Overall length L	63 mm
Flute length L_c	21 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	DIN 6527
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	yes
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
Air	Suitable