Data sheet

Solid carbide milling cutter HPC, TiSi, ∅ f8 DC: 3mm

Order data

Order number	203014 3
GTIN	4045197550965
Item class	12X

Description

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

Technical description

Recess ∅ D_1	2.8 mm
Corner chamfer width at 45°	0.1 mm
Feed f_z for slot milling in stainless steel > 900 N/mm^2	0.012 mm
No. of teeth Z	4
Cutting edge ∅ D_C	3 mm
Overhang length L_1 incl. recess	13 mm
Feed f_z for side milling in INOX > 900 N/mm^2	0.015 mm
Shank ∅ D_s	6 mm
Overall length L	57 mm
Flute length L_c	8 mm
Direction of infeed	horizontal, oblique and vertical
Shank	DIN 6535 HB to h6
Tolerance nominal ∅	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/mm²	suitable	240 m/min	P
Steel < 750 N/mm²	suitable	220 m/min	P
Steel < 900 N/mm²	suitable	180 m/min	P
Steel < 1100 N/mm²	suitable	180 m/min	P
Steel < 1400 N/mm²	suitable	150 m/min	P
TOOLOX 33	suitable	115 m/min	H
TOOLOX 44	suitable	80 m/min	H
INOX < 900 N/mm²	suitable	90 m/min	M
INOX > 900 N/mm²	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