



## Solid carbide milling cutter with internal coolant supply HPC, TiSi, Ø f8 DC: 20mm



### Order data

Order number	203017 20
GTIN	4045197591579
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 side milling in INOX > 900 N/mm <sup>2</sup>	0.08 mm
Cutting edge Ø $D_c$	20 mm
Corner chamfer width at 45°	0.3 mm
Recess Ø $D_1$	19.5 mm
Feed $f_z$ for slot milling in stainless steel > 900 N/mm <sup>2</sup>	0.07 mm
No. of teeth Z	4
Overhang length $L_1$ incl. recess	52 mm
Shank Ø $D_s$	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	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 <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
Air	Suitable