HOLEX

Solid carbide milling cutter with chip separators TPC, TiSiN, ⌀ e8 DC: 6mm

Order data

Order number	203086 6
GTIN	4062406569372
Item class	12X

Description

Version:
High-performance end mill for general-purpose applications, **specially designed for TPC applications**.
Strengthened core.
Optimised bending strength due to the use of ultra-fine grain substrates.
Chip breaker for controlled chip breaking.
Note:
h_{max}: The values stated in the table are maximum values.
$a_{e\,max}$ = 0.07×D for TPC machining.

Technical description

No. of teeth Z	4
Flute length L_c	24 mm
Balance quality with shank	G 2.5 with HB
Cutting edge ⌀ D_C	6 mm
Overall length L	70 mm
Shank ⌀ D_s	6 mm
Tolerance nominal ⌀	e8
Overhang length L_1 incl. recess	30 mm
Helix angle	40 degrees
Direction of infeed	horizontal and oblique

Corner chamfer width at 45°	0.1 mm
Recess Ø D_1	5.8 mm
Corner chamfer angle	45 degrees
Shank	DIN 6535 HB to h6
Average chip thickness h_{max} for TPC milling in steel < 900 N/mm²	0.058 mm
Coating	TiSiN
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	0.07×D
Through-coolant	no
Machining strategy	TPC
Colour ring	green
Type of product	End / face mill

User data

	Suitability	V_c	ISO code
Steel < 500 N/mm²	suitable	350 m/min	P
Steel < 750 N/mm²	suitable	320 m/min	P
Steel < 900 N/mm²	suitable	280 m/min	P
Steel < 1100 N/mm²	suitable	210 m/min	P
Steel < 1400 N/mm²	suitable	135 m/min	P
INOX < 900 N/mm²	suitable	170 m/min	M
INOX > 900 N/mm²	suitable	145 m/min	M
Uni	suitable		

dry	Suitable only under restricted conditions
Air	suitable