



Solid carbide milling cutter with chip separators TPC, TiSiN, Ø e8 DC: 16mm



Order data

| | |
|--------------|---------------|
| Order number | 203085 16 |
| GTIN | 4062406569358 |
| 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.

$a_{e,max} = 0.18 \times D$ for TPC machining.

Technical description

| | |
|------------------------------------|------------------------|
| Balance quality with shank | G 2.5 with HB |
| Shank Ø D_s | 16 mm |
| Direction of infeed | horizontal and oblique |
| Overhang length L_1 incl. recess | 55 mm |
| Corner chamfer angle | 45 degrees |
| No. of teeth Z | 4 |
| Cutting edge Ø D_c | 16 mm |
| Helix angle | 40 degrees |
| Recess Ø D_1 | 15.8 mm |
| Overall length L | 110 mm |

| | |
|---|-------------------------|
| Shank | DIN 6535 HB to h6 |
| Tolerance nominal \varnothing | e8 |
| Flute length L_c | 48 mm |
| Corner chamfer width at 45° | 0.32 mm |
| Average chip thickness h_{max} for TPC milling in steel < 900 N/mm ² | 0.12 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 | 0.18×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/mm ² | suitable | 360 m/min | P |
| Steel < 750 N/mm ² | suitable | 330 m/min | P |
| Steel < 900 N/mm ² | suitable | 290 m/min | P |
| Steel < 1100 N/mm ² | suitable | 220 m/min | P |
| Steel < 1400 N/mm ² | suitable | 140 m/min | P |
| INOX < 900 N/mm ² | suitable | 180 m/min | M |
| INOX > 900 N/mm ² | suitable | 150 m/min | M |
| Uni | suitable | | |
| dry | suitable | | |

Air

suitable