



Solid carbide milling cutter with chip separators TPC, TiSiN, Ø e8 DC: 10mm



Order data

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|--------------|---------------|
| Order number | 203086 10 |
| GTIN | 4062406569396 |
| 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.

$a_{e,max} = 0.07 \times D$ for TPC machining.

Technical description

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|---------------------------------|------------------------|
| Flute length L_c | 40 mm |
| Overall length L | 90 mm |
| Recess $\varnothing D_1$ | 9.8 mm |
| Direction of infeed | horizontal and oblique |
| Tolerance nominal \varnothing | e8 |
| Helix angle | 40 degrees |
| Balance quality with shank | G 2.5 with HB |
| Corner chamfer width at 45° | 0.16 mm |
| Cutting edge $\varnothing D_c$ | 10 mm |
| Shank | DIN 6535 HB to h6 |

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|---|-------------------------|
| Overhang length L_1 incl. recess | 50 mm |
| Shank $\varnothing D_s$ | 10 mm |
| No. of teeth Z | 4 |
| Corner chamfer angle | 45 degrees |
| Average chip thickness h_{max} for TPC milling in steel < 900 N/mm ² | 0.074 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/mm ² | suitable | 350 m/min | P |
| Steel < 750 N/mm ² | suitable | 320 m/min | P |
| Steel < 900 N/mm ² | suitable | 280 m/min | P |
| Steel < 1100 N/mm ² | suitable | 210 m/min | P |
| Steel < 1400 N/mm ² | suitable | 135 m/min | P |
| INOX < 900 N/mm ² | suitable | 170 m/min | M |
| INOX > 900 N/mm ² | suitable | 145 m/min | M |
| Uni | suitable | | |

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| dry | Suitable only under restricted conditions |
| Air | suitable |