



Solid carbide milling cutter with chip separators TPC, TiSiN, Ø e8 DC: 20mm



Order data

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| Order number | 203087 20 |
| GTIN | 4062406569488 |
| 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.

$a_{e,max} = 0.05 \times D$ for TPC machining.

Technical description

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|------------------------------------|------------------------|
| Tolerance nominal Ø | e8 |
| Overhang length L_1 incl. recess | 120 mm |
| Corner chamfer width at 45° | 0.4 mm |
| Balance quality with shank | G 2.5 with HB |
| Shank | DIN 6535 HB to h6 |
| Direction of infeed | horizontal and oblique |
| No. of teeth Z | 4 |
| Flute length L_c | 100 mm |
| Shank Ø D_s | 20 mm |
| Cutting edge Ø D_c | 20 mm |

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|--|-------------------------|
| Corner chamfer angle | 45 degrees |
| Overall length L | 175 mm |
| Helix angle | 40 degrees |
| Recess $\varnothing D_1$ | 19.8 mm |
| Average chip thickness h_{\max} for TPC milling in steel < 900 N/mm ² | 0.134 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 | 0.05×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 | 340 m/min | P |
| Steel < 750 N/mm ² | suitable | 300 m/min | P |
| Steel < 900 N/mm ² | suitable | 260 m/min | P |
| Steel < 1100 N/mm ² | suitable | 190 m/min | P |
| Steel < 1400 N/mm ² | suitable | 115 m/min | P |
| INOX < 900 N/mm ² | suitable | 160 m/min | M |
| INOX > 900 N/mm ² | suitable only under restricted conditions | 110 m/min | M |
| Uni | suitable | | |

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| dry | suitable |
| Air | suitable |