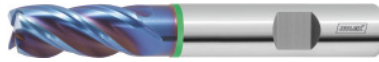




Solid carbide roughing end mill HPC, TiXSi, Ø f8 DC: 4mm



Order data

Order number	203044 4
GTIN	4045197679345
Item class	12X

Description

Version:

For **roughing and finishing**.

Up to $1.5 \times D$ into solid material **at very high feed rates** with smooth cutting action.

Advantage:

Optimised flute form, eccentric relief ground, wide chip space.

Technical description

Feed f_z for side milling in steel $< 900 \text{ N/mm}^2$	0.025 mm
No. of teeth Z	4
Cutting edge $\varnothing D_c$	4 mm
Overhang length L_1 incl. recess	17 mm
Feed f_z for slot milling in steel $< 900 \text{ N/mm}^2$	0.02 mm
Recess $\varnothing D_1$	3.8 mm
Corner chamfer width at 45°	0.1 mm
Shank $\varnothing D_s$	6 mm
Overall length L	57 mm
Flute length L_c	11 mm
Direction of infeed	horizontal, oblique and vertical
Shank	DIN 6535 HB to h6
Tolerance nominal \varnothing	f8

Data sheet

Helix angle	38 degrees
Corner chamfer angle	45 degrees
Coating	TiXSi
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	no
Machining strategy	HPC
Colour ring	green
Type of product	End / face mill

User data

	Suitability	V_c	ISO code
Steel < 500 N/mm ²	suitable	250 m/min	P
Steel < 750 N/mm ²	suitable	200 m/min	P
Steel < 900 N/mm ²	suitable	180 m/min	P
Steel < 1100 N/mm ²	suitable	160 m/min	P
INOX < 900 N/mm ²	suitable only under restricted conditions	70 m/min	M
GG(G)	suitable only under restricted conditions	120 m/min	K
Uni	suitable		
wet maximum	suitable		
wet minimum	suitable only under restricted conditions		
dry	suitable		

Air

suitable