



Solid carbide roughing end mill HPC, TiXSi, Ø DC: 20mm



Order data

Order number	203047 20
GTIN	4045197679505
Item class	12X

Description

Version:

For **roughing and finishing**.

Up to $0.7 \times D$ into solid material **at very high feed rates** with smooth cutting action.

Without dynamic twist pitch.

Advantage:

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

Technical description

Feed f_z for slot milling in steel $< 900 \text{ N/mm}^2$	0.1 mm
Corner chamfer width at 45°	0.3 mm
No. of teeth Z	4
Overhang length L_1 incl. recess	74 mm
Recess $\varnothing D_1$	19.5 mm
Feed f_z for side milling in steel $< 900 \text{ N/mm}^2$	0.13 mm
Cutting edge $\varnothing D_c$	20 mm
Shank $\varnothing D_s$	20 mm
Overall length L	126 mm
Flute length L_c	60 mm
Direction of infeed	horizontal, oblique and vertical
Shank	DIN 6535 HB to h6

Tolerance nominal \varnothing	f8
Helix angle	38 degrees
Corner chamfer angle	45 degrees
Coating	TiXSi
Tool material	Solid carbide
Standard	Manufacturer's standard
Type	N
Spacing of the cutters	unequal spacing
Cutting width a_e for milling operation	0.25×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