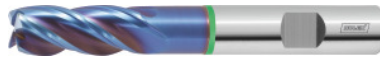




## Solid carbide roughing end mill HPC, TiXSi, Ø DC: 6mm



### Order data

Order number	203047 6
GTIN	4045197679451
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 $< 900 \text{ N/mm}^2$	0.04 mm
Corner chamfer width at $45^\circ$	0.1 mm
No. of teeth Z	4
Feed $f_z$ for side milling in steel $< 900 \text{ N/mm}^2$	0.05 mm
Recess $\varnothing D_1$	5.8 mm
Overhang length $L_1$ incl. recess	24 mm
Cutting edge $\varnothing D_c$	6 mm
Shank $\varnothing D_s$	6 mm
Overall length L	62 mm
Flute length $L_c$	18 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 <sup>2</sup>	suitable	250 m/min	P
Steel < 750 N/mm <sup>2</sup>	suitable	200 m/min	P
Steel < 900 N/mm <sup>2</sup>	suitable	180 m/min	P
Steel < 1100 N/mm <sup>2</sup>	suitable	160 m/min	P
INOX < 900 N/mm <sup>2</sup>	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