

Solid carbide milling cutter HPC, TiAlN, Ø e8 DC: 20mm

Order data

Order number	202770 20
GTIN	4067263119012
Item class	12Z

Description

Version:

Extremely attractively priced solid carbide milling cutter for machining steels and corrosion-resistant steels. No special sizes or versions are available.

Dimensions similar to DIN 6527.

Technical description

No. of teeth Z	4
Feed f_z for side milling in steel < 900 N/mm ²	0.1 mm
Feed f_z for slot milling in stainless steel > 900 N/mm ²	0.06 mm
Shank Ø D_s	20 mm
Shank	DIN 6535 HB to h6
Feed f_z for side milling in INOX > 900 N/mm ²	0.07 mm
Feed f_z for slot milling in steel < 900 N/mm ²	0.09 mm
Cutting edge Ø D_c	20 mm
Flute length L_c	44 mm
Direction of infeed	horizontal, oblique and vertical
Tolerance nominal Ø	e8
Corner chamfer width at 45°	0.3 mm
Overall length L	104 mm
Corner chamfer angle	45 degrees
Helix angle	42 degrees

Coating	TiAlN
Tool material	Solid carbide
Standard	Works standard
Type	N
Helix angle characteristic	unequal spacing
Spacing of the cutters	unequal spacing
Cutting width a_e for milling operation	Full slot cutting depth $1 \times D$
Cutting width a_e for milling operation	$0.3 \times D$ for side milling
Through-coolant	no
Machining strategy	HPC
Type of product	End / face mill

User data

	Suitability	V_c	ISO code
Aluminium (short chipping)	suitable only under restricted conditions	230 m/min	N
Steel < 500 N/mm ²	suitable	220 m/min	P
Steel < 750 N/mm ²	suitable	200 m/min	P
Steel < 900 N/mm ²	suitable	160 m/min	P
Steel < 1100 N/mm ²	suitable	150 m/min	P
Steel < 1400 N/mm ²	suitable	120 m/min	P
INOX < 900 N/mm ²	suitable	80 m/min	M
INOX > 900 N/mm ²	suitable	70 m/min	M
Ti > 850 N/mm ²	suitable only under restricted conditions		
GG(G)	suitable	220 m/min	K
Uni	suitable		
wet maximum	suitable		
wet minimum	suitable only under restricted conditions		

dry	suitable
Air	suitable