Data sheet

Solid carbide milling cutter with chip separators TPC, TiAlN, ⌀ f8 DC: 5mm

Order data

Order number	203106 5
GTIN	4069515013260
Item class	11X

Description

Version:
High-performance milling cutter with irregular cutter spacing and irregular helical pitch. Optimised bending strength due to the use of ultra-fine grain substrates. Offset chip breakers for controlled chip breaking.
Note:
ae max= 0.07×D for TPC machining. hmax: The values stated in the table are maximum values. For finishing operations we recommend items No. 204012, 204014 and 204015. NEW GENERATION AVAILABLE! Recommended successor product is No. 203117.

Technical description

Overall length L	62 mm
Corner chamfer angle	45 degrees
Tolerance nominal ⌀	f8
Direction of infeed	horizontal, oblique and vertical
Shank ⌀ D_s	6 mm
Average chip thickness h_{max} for TPC milling in INOX < 900 N/mm^2	0.023 mm
Overhang length L_1 incl. recess	24 mm
Number of chip separators	1
Flute length L_c	17 mm
Helix angle	40 degrees

No. of teeth Z	7
Balance quality with shank	G 2.5 with HB
Corner chamfer width at 45°	0.1 mm
Shank	DIN 6535 HB to h6
Recess Ø D_1	4.8 mm
Cutting edge Ø D_C	5 mm
Coating	TiAlN
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	0.07×D
Through-coolant	no
Machining strategy	TPC
Colour ring	blue
Type of product	End / face mill

User data

	Suitability	V_c	ISO code
Steel < 500 N/mm²	suitable	380 m/min	P
Steel < 750 N/mm²	suitable	340 m/min	P
Steel < 900 N/mm²	suitable	300 m/min	P
Steel < 1100 N/mm²	suitable	230 m/min	P
INOX < 900 N/mm²	suitable	240 m/min	M
INOX > 900 N/mm²	suitable	170 m/min	M
wet maximum	Suitable		
wet minimum	Suitable only under restricted conditions		

Air	suitable