

Solid carbide milling cutter with chip separators TPC, TiAlN, Ø f8 DC: 4mm**Order data**

Order number	203106 4
GTIN	4069515013277
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:

$a_e \max = 0.07 \times D$ for TPC machining. $h_{\max}$: 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

Flute length L_c	16 mm
No. of teeth Z	7
Corner chamfer angle	45 degrees
Tolerance nominal $\varnothing$	f8
Cutting edge $\varnothing D_c$	4 mm
Overhang length L_1 incl. recess	23 mm
Recess $\varnothing D_1$	3.9 mm
Corner chamfer width at 45°	0.08 mm
Average chip thickness $h_{\max}$ for TPC milling in INOX < 900 N/mm ²	0.018 mm
Shank	DIN 6535 HB to h6

Data sheet

Shank Ø D _s	6 mm
Number of chip separators	1
Direction of infeed	horizontal, oblique and vertical
Balance quality with shank	G 2.5 with HB
Overall length L	62 mm
Helix angle	40 degrees
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/mm ²	suitable	380 m/min	P
Steel < 750 N/mm ²	suitable	340 m/min	P
Steel < 900 N/mm ²	suitable	300 m/min	P
Steel < 1100 N/mm ²	suitable	230 m/min	P
INOX < 900 N/mm ²	suitable	240 m/min	M
INOX > 900 N/mm ²	suitable	170 m/min	M
wet maximum	Suitable		
wet minimum	Suitable only under restricted conditions		

Air

suitable