

Solid carbide milling cutter with chip separators TPC, TiAlN, Ø f8 DC: 8mm**Order data**

Order number	203106 8
GTIN	4069515013246
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

Direction of infeed	horizontal, oblique and vertical
Recess $\varnothing D_1$	7.8 mm
Overall length L	68 mm
Tolerance nominal $\varnothing$	e8
Flute length L_c	24 mm
Corner chamfer width at 45°	0.16 mm
Shank $\varnothing D_s$	8 mm
Cutting edge $\varnothing D_c$	8 mm
Helix angle	40 degrees
Number of chip separators	1
Balance quality with shank	G 2.5 with HB

Data sheet

Overhang length L_1 incl. recess	30 mm
Average chip thickness $h_{\max}$ for TPC milling in INOX < 900 N/mm ²	0.042 mm
Shank	DIN 6535 HB to h6
Corner chamfer angle	45 degrees
No. of teeth Z	7
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	$0.07 \times D$
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