


Solid carbide milling cutter, TiAlN, Ø DC: 4mm

Order data

Order number	203617 4
GTIN	4045197958471
Item class	12X

Description
Version:

For **finishing operations**. Special geometry for optimum chip evacuation. For **profile milling as a finishing operation**. Very sturdy version with strengthened core.

Technical description

Tolerance nominal Ø	h10
Overall length L	54 mm
Direction of infeed	horizontal
Shank	DIN 6535 HA to h6
Feed f_z for side milling in steel < 900 N/mm ²	0.032 mm
No. of teeth Z	6
Shank Ø D_s	6 mm
Cutting edge Ø D_c	4 mm
Flute length L_c	8 mm
Helix angle	45 degrees
Corner chamfer angle	90 degrees
Coating	TiAlN
Tool material	Solid carbide
Standard	Manufacturer's standard

Type	N
Cutting width a_e for milling operation	0.1×D for side milling
Through-coolant	no
Colour ring	without
Type of product	End / face mill

User data

	Suitability	V_c	ISO code
Steel < 500 N/mm ²	suitable	160 m/min	P
Steel < 750 N/mm ²	suitable	140 m/min	P
Steel < 900 N/mm ²	suitable	120 m/min	P
Steel < 1100 N/mm ²	suitable	110 m/min	P
Steel < 1400 N/mm ²	suitable	100 m/min	P
Steel < 55 HRC	suitable	70 m/min	H
Steel < 60 HRC	suitable	60 m/min	H
wet maximum	suitable		
wet minimum	Suitable only under restricted conditions		
dry	Suitable		
Air	Suitable		

Services

Shank grinding Type HB	129100 HB
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