



Solid carbide milling cutter with chip separators TPC, TiSiN, Ø e8 DC: 20 mm



Order data

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|--------------|---------------|
| Order number | 203086 20 |
| GTIN | 4062406569426 |
| Item class | 12X |

Description

Version:

High-performance end mill for general-purpose applications, **specially designed for TPC applications.**

Strengthened core.

Optimised bending strength due to the use of ultra-fine grain substrates.

Chip breaker for controlled chip breaking.

Note:

h_{max} : The values stated in the table are maximum values.

$a_{e\ max} = 0.05 \times D$ for TPC machining.

Tolerance nominal Ø: e8

No. of teeth Z: 4

Helix angle: 40 degrees

Direction of infeed: horizontal and oblique

Shank: DIN 6535 HB to h6

Balance quality with shank: G 2.5 with HB

No. of teeth Z: 4

Flute length L_c : 80 mm

Overhang length L_1 incl. recess: 100 mm

Recess Ø D_1 : 19.8 mm

Overall length L: 150 mm

Shank Ø D_s : 20 mm

Technical description

| | |
|----------------------|------------|
| Corner chamfer angle | 45 degrees |
| Flute length L_c | 80 mm |

| | |
|---|-------------------------|
| Shank $\varnothing D_s$ | 20 mm |
| Cutting edge $\varnothing D_c$ | 20 mm |
| Shank | DIN 6535 HB to h6 |
| Recess $\varnothing D_1$ | 19.8 mm |
| No. of teeth Z | 4 |
| Balance quality with shank | G 2.5 with HB |
| Overhang length L_1 incl. recess | 100 mm |
| Overall length L | 150 mm |
| Corner chamfer width at 45° | 0.4 mm |
| Helix angle | 40 degrees |
| Tolerance nominal \varnothing | e8 |
| Direction of infeed | horizontal and oblique |
| Average chip thickness h_{max} for TPC milling in steel < 900 N/mm ² | 0.134 mm |
| Coating | TiSiN |
| 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 | green |
| Type of product | End mill |