

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

Order number	203087 8
GTIN	4062406569440
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.

$a_{e max} = 0.07 \times D$ 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 : 40 mm

Overhang length L_1 incl. recess: 48 mm

Recess Ø D_1 : 7.8 mm

Overall length L: 90 mm

Shank Ø D_s : 8 mm

Technical description

Overhang length L_1 incl. recess	48 mm
Helix angle	40 degrees

Tolerance nominal $\varnothing$	e8
Cutting edge $\varnothing D_c$	8 mm
Corner chamfer angle	45 degrees
Corner chamfer width at 45°	0.12 mm
Balance quality with shank	G 2.5 with HB
No. of teeth Z	4
Shank $\varnothing D_s$	8 mm
Overall length L	90 mm
Recess $\varnothing D_1$	7.8 mm
Direction of infeed	horizontal and oblique
Flute length L_c	40 mm
Shank	DIN 6535 HB to h6
Average chip thickness h_{max} for TPC milling in steel < 900 N/mm ²	0.062 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	0.05×D
Through-coolant	no
Machining strategy	TPC
Colour ring	green
Type of product	End mill