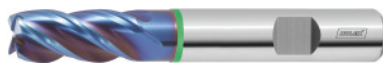



**Solid carbide roughing end mill HPC, TiXSi, Ø f8 DC: 6mm**

**Order data**

|              |               |
|--------------|---------------|
| Order number | 203044 6      |
| GTIN         | 4045197679369 |
| Item class   | 12X           |

**Description**
**Version:**

For **roughing and finishing**.

Up to  $1.5 \times D$  into solid material **at very high feed rates** with smooth cutting action.

**Advantage:**

Optimised flute form, eccentric relief ground, wide chip space.

**Technical description**

|                                                             |                                  |
|-------------------------------------------------------------|----------------------------------|
| Recess Ø $D_1$                                              | 5.8 mm                           |
| Feed $f_z$ for side milling in steel $< 900 \text{ N/mm}^2$ | 0.05 mm                          |
| Overhang length $L_1$ incl. recess                          | 19 mm                            |
| Cutting edge Ø $D_c$                                        | 6 mm                             |
| Feed $f_z$ for slot milling in steel $< 900 \text{ N/mm}^2$ | 0.04 mm                          |
| Corner chamfer width at $45^\circ$                          | 0.1 mm                           |
| No. of teeth $Z$                                            | 4                                |
| Shank Ø $D_s$                                               | 6 mm                             |
| Overall length $L$                                          | 57 mm                            |
| Flute length $L_c$                                          | 13 mm                            |
| Direction of infeed                                         | horizontal, oblique and vertical |
| Shank                                                       | DIN 6535 HB to h6                |
| Tolerance nominal Ø                                         | f8                               |

|                                           |                                      |
|-------------------------------------------|--------------------------------------|
| Helix angle                               | 38 degrees                           |
| Corner chamfer angle                      | 45 degrees                           |
| Coating                                   | TiXSi                                |
| Tool material                             | Solid carbide                        |
| Standard                                  | DIN 6527                             |
| Type                                      | N                                    |
| Helix angle characteristic                | unequal spacing                      |
| Spacing of the cutters                    | unequal spacing                      |
| Cutting width $a_e$ for milling operation | $0.3 \times D$ for side milling      |
| Cutting width $a_e$ for milling operation | Full slot cutting depth $1 \times D$ |
| Through-coolant                           | no                                   |
| Machining strategy                        | HPC                                  |
| Colour ring                               | green                                |
| Type of product                           | End / face mill                      |

## User data

|                                | Suitability                               | $V_c$     | ISO code |
|--------------------------------|-------------------------------------------|-----------|----------|
| Steel < 500 N/mm <sup>2</sup>  | suitable                                  | 250 m/min | P        |
| Steel < 750 N/mm <sup>2</sup>  | suitable                                  | 200 m/min | P        |
| Steel < 900 N/mm <sup>2</sup>  | suitable                                  | 180 m/min | P        |
| Steel < 1100 N/mm <sup>2</sup> | suitable                                  | 160 m/min | P        |
| INOX < 900 N/mm <sup>2</sup>   | suitable only under restricted conditions | 70 m/min  | M        |
| GG(G)                          | suitable only under restricted conditions | 120 m/min | K        |
| Uni                            | suitable                                  |           |          |
| wet maximum                    | suitable                                  |           |          |
| wet minimum                    | suitable only under restricted conditions |           |          |
| dry                            | suitable                                  |           |          |

Air

suitable