



Solid carbide roughing end mill HPC, TiAlN, Ø d11 DC: 4mm



Order data

Order number	GG1491 4
GTIN	4045197735881
Item class	GGN

Description

Version:

With knuckle profile for roughing.

Very high rate of metal removal.

Can be used as universal roughing end mill.

Without dynamic twist pitch.

Size **16M MID mills: Dimensions to manufacturer's standard.**

Same as No. 205492.

Technical description

No. of teeth Z	3
Flute length L_c	8 mm
Overall length L	57 mm
Feed f_z for slot milling in steel < 900 N/mm ²	0.02 mm
Shank Ø D_s	6 mm
Direction of infeed	horizontal, oblique and vertical
Corner chamfer width at 45°	0.3 mm

Tolerance nominal \varnothing	d11
Feed f_z for side milling in steel < 900 N/mm ²	0.023 mm
Cutting edge $\varnothing D_c$	4 mm
Shank	DIN 6535 HB to h6
Helix angle	30 degrees
Contents	5
Coating	TiAlN
Tool material	Solid carbide
Standard	DIN 6527
Milling profile	HR
Cutting width a_e for milling operation	0.5×D for side milling
Cutting width a_e for milling operation	Full slot cutting depth 1×D
Machining strategy	HPC
Colour ring	without
Type of product	End / face mill

User data

	Suitability	V_c	ISO code
Aluminium (short chipping)	suitable only under restricted conditions	270 m/min	N
Alu > 10% Si	suitable only under restricted conditions	190 m/min	N
Steel < 500 N/mm ²	suitable	115 m/min	P
Steel < 750 N/mm ²	suitable	100 m/min	P
Steel < 900 N/mm ²	suitable	95 m/min	P
Steel < 1100 N/mm ²	suitable	65 m/min	P
Steel < 1400 N/mm ²	suitable	55 m/min	P
INOX > 900 N/mm ²	suitable only under restricted conditions	55 m/min	M
GG(G)	suitable	85 m/min	K

Uni	suitable only under restricted conditions
wet maximum	suitable
wet minimum	suitable only under restricted conditions
dry	suitable only under restricted conditions
Air	suitable

Accessories

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