

**Solid carbide roughing end mill HPC, TiAlN, Ø d11 DC: 12mm****Order data**

Order number	GG1491 12
GTIN	4045197735935
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**

Shank Ø D <sub>s</sub>	12 mm
Flute length L <sub>c</sub>	26 mm
Feed f <sub>z</sub> for slot milling in steel < 900 N/mm <sup>2</sup>	0.06 mm
Feed f <sub>z</sub> for side milling in steel < 900 N/mm <sup>2</sup>	0.08 mm
Cutting edge Ø D <sub>c</sub>	12 mm
No. of teeth Z	4
Tolerance nominal Ø	d11

Direction of infeed	horizontal, oblique and vertical
Shank	DIN 6535 HB to h6
Corner chamfer width at 45°	0.5 mm
Overall length L	83 mm
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 <sup>2</sup>	suitable	115 m/min	P
Steel < 750 N/mm <sup>2</sup>	suitable	100 m/min	P
Steel < 900 N/mm <sup>2</sup>	suitable	95 m/min	P
Steel < 1100 N/mm <sup>2</sup>	suitable	65 m/min	P
Steel < 1400 N/mm <sup>2</sup>	suitable	55 m/min	P
INOX > 900 N/mm <sup>2</sup>	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

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## Accessories

Solid carbide roughing end millHPC Ø d11 DC 12 mm	205492 12
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