

**Value pack solid carbide mini milling cutter, 5 pieces****Order data**

Order number	GG1844 3
GTIN	4062406200046
Item class	GGN

Description**Version:**

Shank similar to **DIN 6535 HB**. Improved coating for general-purpose applications in steel and cast iron.

Same as No. Z11842 (successor item to No. 201842).

Technical description

Shank form	HB
Direction of infeed	horizontal, oblique and vertical
Feed f_z for side milling in steel $< 900 \text{ N/mm}^2$	0.011 mm
Cutting edge $\varnothing D_c$	3 mm
Correction factor for v_c	1.25
Flute length L_c	5 mm
Tolerance nominal $\varnothing$	e8
Helix angle	30 degrees
Overall length L	36 mm
Shank	DIN 6535 HB to h6

Feed f_z for slot milling in steel $< 900 \text{ N/mm}^2$	0.01 mm
No. of teeth Z	3
Shank $\varnothing D_s$	6 mm
Contents	5
Coating	TiAlN
Tool material	Solid carbide
Standard	Manufacturer's standard
Type	N
Cutting width a_e for milling operation	Full slot cutting depth $1 \times D$
Cutting width a_e for milling operation	$0.03 \times D$ for copy milling
Colour ring	without
Type of product	End / face mill

User data

	Suitability	V_c	ISO code
Aluminium (short chipping)	suitable	280 m/min	N
Alu $> 10\% \text{ Si}$	suitable	200 m/min	N
Steel $< 500 \text{ N/mm}^2$	suitable	120 m/min	P
Steel $< 750 \text{ N/mm}^2$	suitable	110 m/min	P
Steel $< 900 \text{ N/mm}^2$	suitable	100 m/min	P
Steel $< 1100 \text{ N/mm}^2$	suitable	70 m/min	P
Steel $< 1400 \text{ N/mm}^2$	suitable	60 m/min	P
INOX $< 900 \text{ N/mm}^2$	suitable	70 m/min	M
INOX $> 900 \text{ N/mm}^2$	suitable	50 m/min	M
GG(G)	suitable	90 m/min	K
Uni	suitable		
wet maximum	suitable		
wet minimum	suitable		

dry	suitable only under restricted conditions
Air	suitable