

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

Order number	GG1844 5
GTIN	4062406200091
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

Correction factor for v_c	1.25
Shank	DIN 6535 HB to h6
Direction of infeed	horizontal, oblique and vertical
Cutting edge $\varnothing D_c$	5 mm
Flute length L_c	8 mm
Shank form	HB
No. of teeth Z	3
Helix angle	30 degrees
Tolerance nominal $\varnothing$	e8
Shank $\varnothing D_s$	6 mm

Feed f_z for slot milling in steel < 900 N/mm ²	0.02 mm
Feed f_z for side milling in steel < 900 N/mm ²	0.023 mm
Overall length L	39 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×D
Cutting width a_e for milling operation	0.03×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% Si	suitable	200 m/min	N
Steel < 500 N/mm ²	suitable	120 m/min	P
Steel < 750 N/mm ²	suitable	110 m/min	P
Steel < 900 N/mm ²	suitable	100 m/min	P
Steel < 1100 N/mm ²	suitable	70 m/min	P
Steel < 1400 N/mm ²	suitable	60 m/min	P
INOX < 900 N/mm ²	suitable	70 m/min	M
INOX > 900 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