

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

Order number	GG1844 1,2
GTIN	4062406199982
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

No. of teeth Z	3
Helix angle	30 degrees
Feed f_z for side milling in steel $< 900 \text{ N/mm}^2$	0.006 mm
Cutting edge $\varnothing D_c$	1.2 mm
Flute length L_c	2 mm
Tolerance nominal $\varnothing$	e8
Feed f_z for slot milling in steel $< 900 \text{ N/mm}^2$	0.005 mm
Shank form	HA
Direction of infeed	horizontal, oblique and vertical
Overall length L	38 mm

Shank	DIN 6535 HA to h6
Shank Ø D _s	3 mm
Correction factor for v _c	1.25
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