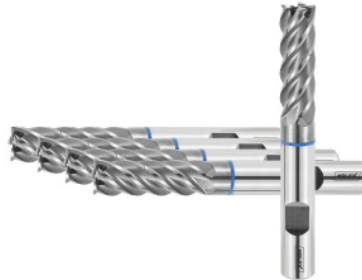




Solid carbide milling cutter with chip separators TPC, TiAlN, Ø f8 DC: 20mm



Order data

Order number	GG3109 20
GTIN	4067263102458
Item class	GGN

Description

Version:

Same as No. 203109.

High-performance milling cutter with **irregular cutter spacing** and **irregular helical pitch**. Optimised bending strength due to the use of ultra-fine grain substrates. **Chip breakers for controlled chip breaking.**

Note:

h_{\max} : The values stated in the table are maximum values.

$a_{e\max} = 0.07 \times D$ for TPC machining.

Technical description

Average chip thickness h_{\max} for TPC milling in INOX < 900 N/mm ²	0.097 mm
No. of teeth Z	5
Flute length L_c	60 mm
Cutting edge $\varnothing D_c$	20 mm
Direction of infeed	horizontal and oblique
Overhang length L_1 incl. recess	70 mm

Shank	DIN 6535 HB to h6
Tolerance nominal \varnothing	e8
Corner chamfer angle	45 degrees
Corner chamfer width at 45°	0.4 mm
Overall length L	126 mm
Balance quality with shank	G 2.5 with HB
Recess $\varnothing D_1$	19.8 mm
Shank $\varnothing D_s$	20 mm
Helix angle	40 degrees
Contents	5
Coating	TiAlN
Tool material	Solid carbide
Standard	Manufacturer's standard
Type	N
Helix angle characteristic	unequal spacing
Spacing of the cutters	unequal spacing
Cutting width a_e for milling operation	$0.07 \times D$
Through-coolant	no
Machining strategy	TPC
Colour ring	blue
Type of product	End / face mill

User data

	Suitability	V_c	ISO code
Steel < 500 N/mm ²	suitable	380 m/min	P
Steel < 750 N/mm ²	suitable	340 m/min	P
Steel < 900 N/mm ²	suitable	300 m/min	P
Steel < 1100 N/mm ²	suitable	230 m/min	P
INOX < 900 N/mm ²	suitable	240 m/min	M

INOX > 900 N/mm ²	suitable	170 m/min	M
wet maximum	suitable		
wet minimum	suitable only under restricted conditions		
Air	suitable		

Accessories

Solid carbide milling cutter with chip separators TPC Ø f8
DC 20 mm

203109 20