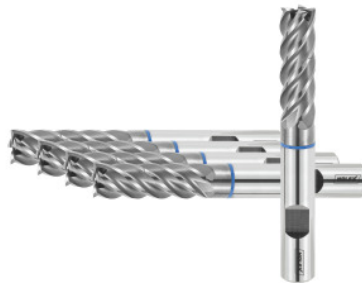


**HOLEX**
**Solid carbide milling cutter with chip separators TPC, TiAlN, Ø f8 DC: 6mm**

**Order data**

Order number	GG3109 6
GTIN	4067263102403
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**

Cutting edge Ø $D_c$	6 mm
Corner chamfer angle	45 degrees
No. of teeth Z	5
Direction of infeed	horizontal and oblique
Overall length L	62 mm
Corner chamfer width at 45°	0.12 mm
Recess Ø $D_1$	5.8 mm

Tolerance nominal $\varnothing$	e8
Helix angle	40 degrees
Flute length $L_c$	18 mm
Balance quality with shank	G 2.5 with HB
Average chip thickness $h_{max}$ for TPC milling in INOX < 900 N/mm <sup>2</sup>	0.032 mm
Shank	DIN 6535 HB to h6
Overhang length $L_1$ incl. recess	25 mm
Shank $\varnothing D_s$	6 mm
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×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 <sup>2</sup>	suitable	380 m/min	P
Steel < 750 N/mm <sup>2</sup>	suitable	340 m/min	P
Steel < 900 N/mm <sup>2</sup>	suitable	300 m/min	P
Steel < 1100 N/mm <sup>2</sup>	suitable	230 m/min	P
INOX < 900 N/mm <sup>2</sup>	suitable	240 m/min	M

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

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## Accessories

Solid carbide milling cutter with chip separators TPC Ø f8  
DC 6 mm

203109 6