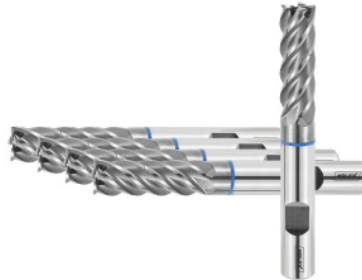




## Solid carbide milling cutter with chip separators TPC, TiAlN, Ø f8 DC: 8mm



### Order data

Order number	GG3109 8
GTIN	4067263102410
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

Overall length L	68 mm
Flute length $L_c$	24 mm
Corner chamfer angle	45 degrees
Shank Ø $D_s$	8 mm
Balance quality with shank	G 2.5 with HB
Recess Ø $D_1$	7.8 mm
No. of teeth Z	5

Direction of infeed	horizontal and oblique
Cutting edge $\varnothing D_c$	8 mm
Tolerance nominal $\varnothing$	e8
Overhang length $L_1$ incl. recess	30 mm
Shank	DIN 6535 HB to h6
Helix angle	40 degrees
Corner chamfer width at 45°	0.16 mm
Average chip thickness $h_{max}$ for TPC milling in INOX < 900 N/mm <sup>2</sup>	0.042 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 8 mm

203109 8