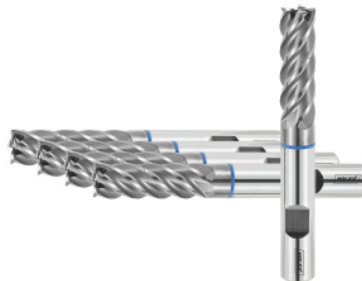


HOLEX
Solid carbide milling cutter with chip separators TPC, TiAlN, Ø f8 DC: 5mm

Order data

| | |
|--------------|---------------|
| Order number | GG3109 5 |
| GTIN | 4067263102397 |
| 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 | 62 mm |
| Flute length L_c | 17 mm |
| Recess $\varnothing D_1$ | 4.8 mm |
| Shank | DIN 6535 HB to h6 |
| Helix angle | 40 degrees |
| Corner chamfer width at 45° | 0.1 mm |
| Direction of infeed | horizontal and oblique |

| | |
|--|-------------------------|
| Shank $\varnothing D_s$ | 6 mm |
| No. of teeth Z | 5 |
| Corner chamfer angle | 45 degrees |
| Tolerance nominal \varnothing | e8 |
| Balance quality with shank | G 2.5 with HB |
| Overhang length L_1 incl. recess | 24 mm |
| Cutting edge $\varnothing D_c$ | 5 mm |
| Average chip thickness h_{max} for TPC milling in INOX < 900 N/mm ² | 0.023 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 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 5 mm

203109 5