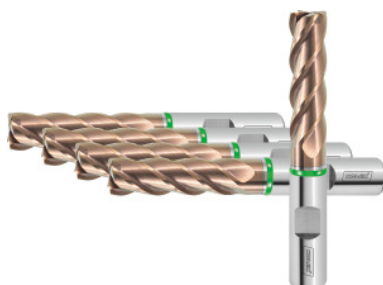




Value pack solid carbide milling cutter with chip separators TPC, 5 pieces



Order data

Order number	GG3085 4
GTIN	4062406625740
Item class	GGN

Description

Version:

High-performance end mill for general-purpose applications, **specially designed for TPC applications.**

Strengthened core.

Optimised bending strength due to the use of ultra-fine grain substrates.

Chip breaker for controlled chip breaking.

Same as No. 203085.

Note:

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

$a_{e \max} = 0.18 \times D$ for TPC machining.

Technical description

Flute length L_c	16 mm
Helix angle	40 degrees
Direction of infeed	horizontal and oblique
Shank $\varnothing D_s$	6 mm
Overall length L	62 mm
No. of teeth Z	4

Shank	DIN 6535 HB to h6
Average chip thickness $h_{\max}$ for TPC milling in steel < 900 N/mm ²	0.046 mm
Balance quality with shank	G 2.5 with HB
Tolerance nominal $\varnothing$	e8
Corner chamfer width at 45°	0.08 mm
Overhang length L_1 incl. recess	23 mm
Recess $\varnothing D_1$	3.9 mm
Cutting edge $\varnothing D_c$	4 mm
Corner chamfer angle	45 degrees
Contents	5
Coating	TiSiN
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	0.18×D
Through-coolant	no
Machining strategy	TPC
Colour ring	green
Type of product	End / face mill

User data

	Suitability	V_c	ISO code
Steel < 500 N/mm ²	suitable	360 m/min	P
Steel < 750 N/mm ²	suitable	330 m/min	P
Steel < 900 N/mm ²	suitable	290 m/min	P
Steel < 1100 N/mm ²	suitable	220 m/min	P

Steel < 1400 N/mm ²	suitable	140 m/min	P
INOX < 900 N/mm ²	suitable	180 m/min	M
INOX > 900 N/mm ²	suitable	150 m/min	M
Uni	suitable		
dry	suitable		
Air	suitable		

Accessories

Solid carbide milling cutter with chip separatorsTPC Ø e8
DC 4 mm

203085 4