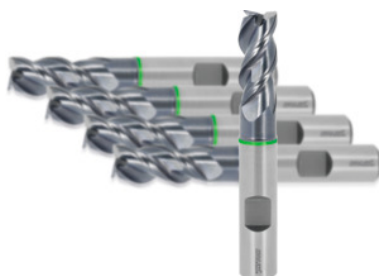


**Value pack HOLEX Pro Steel HPC solid carbide roughing end mill, 5 pieces****Order data**

|              |               |
|--------------|---------------|
| Order number | GG1414 17,5   |
| GTIN         | 4045197908292 |
| Item class   | GGN           |

**Description****Version:**

For **roughing and finishing**.

Up to  $1 \times D$  into solid material **at very high feed rates** with smooth cutting action.

**Same as No. 202414.**

**Advantage:**

Optimised flute form, eccentric relief ground, generous chip spaces.

**Technical description**

|                                    |                                  |
|------------------------------------|----------------------------------|
| Corner chamfer width at 45°        | 0.4 mm                           |
| Tolerance nominal $\varnothing$    | 0 / -0.03                        |
| Overhang length $L_1$ incl. recess | 50 mm                            |
| Flute length $L_c$                 | 32 mm                            |
| Recess $\varnothing D_1$           | 17 mm                            |
| Shank $\varnothing D_s$            | 18 mm                            |
| Cutting edge $\varnothing D_c$     | 17.5 mm                          |
| Direction of infeed                | horizontal, oblique and vertical |

## Data sheet

|                                                              |                             |
|--------------------------------------------------------------|-----------------------------|
| Feed $f_z$ for slot milling in steel < 900 N/mm <sup>2</sup> | 0.1 mm                      |
| No. of teeth Z                                               | 3                           |
| Overall length L                                             | 92 mm                       |
| Shank                                                        | DIN 6535 HB to h6           |
| Feed $f_z$ for side milling in steel < 900 N/mm <sup>2</sup> | 0.13 mm                     |
| Helix angle                                                  | 45 degrees                  |
| Corner chamfer angle                                         | 45 degrees                  |
| Contents                                                     | 5                           |
| Series                                                       | Pro Steel                   |
| 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                    | Full slot cutting depth 1×D |
| Cutting width $a_e$ for milling operation                    | 0.4×D for side milling      |
| Machining strategy                                           | HPC                         |
| Colour ring                                                  | green                       |
| Type of product                                              | End / face mill             |

## User data

|                                | Suitability                               | $V_c$     | ISO code |
|--------------------------------|-------------------------------------------|-----------|----------|
| Steel < 500 N/mm <sup>2</sup>  | suitable                                  | 240 m/min | P        |
| Steel < 750 N/mm <sup>2</sup>  | suitable                                  | 220 m/min | P        |
| Steel < 900 N/mm <sup>2</sup>  | suitable                                  | 170 m/min | P        |
| Steel < 1100 N/mm <sup>2</sup> | suitable                                  | 150 m/min | P        |
| INOX < 900 N/mm <sup>2</sup>   | suitable only under restricted conditions | 80 m/min  | M        |

|             |                                              |           |   |
|-------------|----------------------------------------------|-----------|---|
| GGG         | suitable                                     | 190 m/min | K |
| Uni         | suitable                                     |           |   |
| wet maximum | suitable                                     |           |   |
| wet minimum | suitable only under<br>restricted conditions |           |   |
| dry         | suitable                                     |           |   |
| Air         | suitable                                     |           |   |

**Suitable products**

<https://www.hoffmann-group.com/GB/en/hom/p/GG1414-17,5>