

Garant
Solid carbide roughing end mill MTC, AlCrN, Ø e8 DC: 6mm

Order data

Order number	203051 6
GTIN	4045197774293
Item class	11X

Description
Version:

For **roughing and finishing** up to 1.5xD into solid material **at very high feed rates** with smooth cutting action.

For cutting force reduction and better surface quality due to **45° helix**.

Improved coating for a further reduction in cutting force combined with increased tool life.

Application:

Especially for **MTC (Multi Task Cutting)** use on the new generation of turning / milling centres.

Technical description

Feed f_z for side milling in steel $< 900 \text{ N/mm}^2$	0.07 mm
Shank	DIN 6535 HB to h6
Tolerance nominal Ø	e8
Balance quality with shank	G 2.5 with HB
Shank Ø D_s	6 mm
Flute length L_c	10 mm
Corner chamfer width at 45°	0.1 mm
Cutting edge Ø D_c	6 mm
Overhang length L_1 incl. recess	16 mm
Direction of infeed	horizontal, oblique and vertical
Overall length L	54 mm

Recess $\varnothing D_1$	5.8 mm
No. of teeth Z	4
Helix angle	45 degrees
Corner chamfer angle	45 degrees
Coating	AlCrN
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	0.5×D for side milling
Cutting width a_e for milling operation	Full slot cutting depth 1×D
Through-coolant	no
Machining strategy	MTC
Colour ring	green
Type of product	End / face mill

User data

	Suitability	V_c	ISO code
Steel < 500 N/mm ²	suitable	250 m/min	P
Steel < 750 N/mm ²	suitable	230 m/min	P
Steel < 900 N/mm ²	suitable	200 m/min	P
Steel < 1100 N/mm ²	suitable	180 m/min	P
Steel < 1400 N/mm ²	suitable	150 m/min	P
INOX < 900 N/mm ²	suitable	70 m/min	M
INOX > 900 N/mm ²	suitable	50 m/min	M
GG(G)	suitable	150 m/min	K
Uni	suitable		
wet maximum	suitable		

wet minimum	suitable only under restricted conditions
dry	suitable
Air	suitable