

**Garant**
**Solid carbide roughing end mill MTC / TPC, TiAlN, Ø f8 DC: 8mm**

**Order data**

Order number	202981 8
GTIN	4062406245467
Item class	11X

**Description**
**Version:**

**Significant cutting force reduction** due to 45° helix.

Specially for **trochoidal milling strategy**.

**Application:**

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

**Note:**

For materials > 55 HRC we recommend reducing the depth of cut to  $a_p=0.25 \times D \dots 0.5 \times D$ .

**Technical description**

Shank	DIN 6535 HB to h6
Feed $f_z$ for side milling in steel < 60 HRC	0.025 mm
No. of teeth Z	4
Recess $\varnothing D_1$	7.4 mm
Flute length $L_c$	24 mm
Feed $f_z$ for slot milling in steel < 60 HRC	0.02 mm
Tolerance nominal $\varnothing$	f8
Overall length L	68 mm
Overhang length $L_1$ incl. recess	30 mm
Shank $\varnothing D_s$	8 mm
Helix angle	45 degrees

Cutting edge $\varnothing D_c$	8 mm
Direction of infeed	horizontal, oblique and vertical
Corner rounding $r_v$	0.2 mm
Coating	TiAlN
Tool material	Solid carbide
Standard	Manufacturer's standard
Type	H
Helix angle characteristic	unequal spacing
Spacing of the cutters	unequal spacing
Cutting width $a_e$ for milling operation	Full slot cutting depth $1 \times D$
Cutting width $a_e$ for milling operation	$0.1 \times D$
Cutting width $a_e$ for milling operation	$0.2 \times D$ for side milling
Through-coolant	no
Machining strategy	TPC
Machining strategy	MTC
Colour ring	red
Type of product	End / face mill

## User data

	Suitability	$V_c$	ISO code
Steel < 900 N/mm <sup>2</sup>	suitable	160 m/min	P
Steel < 1100 N/mm <sup>2</sup>	suitable	115 m/min	P
Steel < 1400 N/mm <sup>2</sup>	suitable	115 m/min	P
Steel < 55 HRC	suitable	60 m/min	H
Steel < 60 HRC	suitable	30 m/min	H
Steel < 65 HRC	suitable	25 m/min	H
Steel < 67 HRC	suitable only under restricted conditions	20 m/min	H

wet maximum	suitable only under restricted conditions
wet minimum	suitable only under restricted conditions
dry	suitable
Air	suitable