

Garant

Solid carbide roughing end mill MTC / TPC, TiAlN, Ø f8 DC: 4mm



Order data

Order number	202981 4
GTIN	4062406245436
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

Overhang length L_1 incl. recess	23 mm
Helix angle	45 degrees
No. of teeth Z	4
Feed f_z for side milling in steel < 60 HRC	0.01 mm
Recess $\varnothing D_1$	3.8 mm
Tolerance nominal \varnothing	f8
Feed f_z for slot milling in steel < 60 HRC	0.008 mm
Cutting edge $\varnothing D_c$	4 mm
Shank	DIN 6535 HB to h6
Flute length L_c	16 mm
Overall length L	62 mm

Shank $\varnothing D_s$	6 mm
Direction of infeed	horizontal, oblique and vertical
Corner rounding r_v	0.1 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 ²	suitable	160 m/min	P
Steel < 1100 N/mm ²	suitable	115 m/min	P
Steel < 1400 N/mm ²	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