

Garant
Solid carbide milling cutter MTC, AlCrN, Ø f8 DC: 10mm

Order data

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| Order number | 202391 10 |
| GTIN | 4062406270872 |
| Item class | 11X |

Description
Version:

Special flute profile. Strengthened core.

MTC rough milling up to 1.5×D in solid material.

Eccentric relief ground.

Particularly sturdy due to short overall length. Overall length similar to **DIN 6527 short**.

Application:

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

Technical description

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|--|----------------------------------|
| Flute length L_c | 14 mm |
| Helix angle | 45 degrees |
| No. of teeth Z | 3 |
| Cutting edge $\varnothing D_c$ | 10 mm |
| Feed f_z for side milling in steel < 900 N/mm ² | 0.072 mm |
| Balance quality with shank | G 2.5 with HA |
| Tolerance nominal \varnothing | f8 |
| Corner chamfer width at 45° | 0.15 mm |
| Overhang length L_1 incl. recess | 24 mm |
| Overall length L | 66 mm |
| Direction of infeed | horizontal, oblique and vertical |

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| Shank $\varnothing D_s$ | 10 mm |
| Feed f_z for slot milling in steel < 900 N/mm ² | 0.06 mm |
| Recess $\varnothing D_1$ | 9.8 mm |
| Shank | DIN 6535 HA to h6 |
| Corner chamfer angle | 45 degrees |
| Coating | AlCrN |
| Tool material | Solid carbide |
| Standard | DIN 6527 |
| Type | N |
| Helix angle characteristic | unequal spacing |
| Spacing of the cutters | unequal spacing |
| Cutting width a_e for milling operation | Full slot cutting depth 1xD |
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| 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 | 220 m/min | P |
| Steel < 900 N/mm ² | Suitable | 200 m/min | P |
| Steel < 1100 N/mm ² | Suitable | 190 m/min | P |
| Steel < 1400 N/mm ² | suitable | 170 m/min | P |
| Steel < 55 HRC | suitable | 90 m/min | H |
| Steel < 60 HRC | suitable | 60 m/min | H |
| INOX < 900 N/mm ² | suitable | 130 m/min | M |
| INOX > 900 N/mm ² | Suitable | 100 m/min | M |

| | | | |
|----------------------------|---|-----------|---|
| Ti > 850 N/mm ² | suitable only under restricted conditions | 50 m/min | S |
| GG(G) | suitable | 160 m/min | K |
| Uni | suitable | | |
| wet maximum | Suitable | | |
| wet minimum | suitable only under restricted conditions | | |
| dry | Suitable | | |
| Air | Suitable | | |