

**Garant**
**Solid carbide milling cutter MTC, AlCrN, Ø f8 DC: 5mm**

**Order data**

|              |               |
|--------------|---------------|
| Order number | 202391 5      |
| GTIN         | 4062406270834 |
| 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**

|  |                                  |
|--|----------------------------------|
| Overhang length $L_1$ incl. recess                           | 16 mm                            |
| Recess $\varnothing D_1$                                     | 4.8 mm                           |
| Feed $f_z$ for slot milling in steel < 900 N/mm <sup>2</sup> | 0.04 mm                          |
| Shank  | DIN 6535 HA to h6                |
| Overall length L   | 54 mm                            |
| Flute length $L_c$   | 9 mm                             |
| Direction of infeed  | horizontal, oblique and vertical |
| Corner chamfer width at 45°                                  | 0.08 mm                          |
| Balance quality with shank                                   | G 2.5 with HA                    |
| Cutting edge $\varnothing D_c$                               | 5 mm                             |
| Feed $f_z$ for side milling in steel < 900 N/mm <sup>2</sup> | 0.048 mm                         |

|   |                                      |
|---|--------------------------------------|
| No. of teeth Z                            | 3                                    |
| Tolerance nominal $\varnothing$           | f8                                   |
| Shank $\varnothing D_s$                   | 6 mm                                 |
| Helix angle                               | 45 degrees                           |
| 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 $1 \times D$ |
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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 <sup>2</sup>  | suitable    | 250 m/min | P        |
| Steel < 750 N/mm <sup>2</sup>  | suitable    | 220 m/min | P        |
| Steel < 900 N/mm <sup>2</sup>  | Suitable    | 200 m/min | P        |
| Steel < 1100 N/mm <sup>2</sup> | Suitable    | 190 m/min | P        |
| Steel < 1400 N/mm <sup>2</sup> | 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 <sup>2</sup>   | suitable    | 130 m/min | M        |
| INOX > 900 N/mm <sup>2</sup>   | Suitable    | 100 m/min | M        |

|                            |   |           |   |
|----------------------------|---|-----------|---|
| Ti > 850 N/mm <sup>2</sup> | 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                                  |           |   |