ᛏᛟ Hoffmann Group

Garant

Solid carbide roughing end mill MTC / TPC, TiAlN, Ø f8 DC: 5mm

Order data

Order number	202977 5
GTIN	4045197431356
Item class	11X

Description

Version:
Significant cutting force reduction due to 45° helix.
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×D...0.5×D.

Technical description

Recess Ø D_1	4.7 mm
Corner chamfer width at 45°	0.1 mm
No. of teeth Z	4
Overhang length L_1 incl. recess	18 mm
Feed f_z for side milling in steel < 60 HRC	0.015 mm
Cutting edge Ø D_c	5 mm
Feed f_z for slot milling in steel < 60 HRC	0.01 mm
Shank Ø D_s	6 mm
Overall length L	57 mm
Flute length L_c	13 mm
Direction of infeed	horizontal, oblique and vertical
Shank	DIN 6535 HB to h6

Tolerance nominal Ø	f8
Helix angle	45 degrees
Corner chamfer angle	45 degrees
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×D
Cutting width a_e for milling operation	0.15×D for side milling
Cutting width a_e for milling operation	0.1×D
Through-coolant	no
Machining strategy	MTC
Machining strategy	TPC
Colour ring	red
Type of product	End / face mill

User data

	Suitability	V_c	ISO code
Steel < 900 N/mm²	suitable	160 m/min	P
Steel < 1100 N/mm²	suitable	115 m/min	P
Steel < 1400 N/mm²	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