

Garant
Solid carbide roughing end mill MTC, TiAlN, Ø f8 DC: 6mm

Order data

Order number	202976 6
GTIN	4045197431271
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 $a_p=0.25 \times D \dots 0.5 \times D$.

Technical description

Feed f_z for side milling in steel < 60 HRC	0.02 mm
Corner chamfer width at 45°	0.1 mm
Cutting edge $\varnothing D_c$	6 mm
No. of teeth Z	4
Feed f_z for slot milling in steel < 60 HRC	0.015 mm
Shank $\varnothing D_s$	6 mm
Overall length L	54 mm
Flute length L_c	10 mm
Direction of infeed	horizontal, oblique and vertical
Shank	DIN 6535 HB to h6
Tolerance nominal \varnothing	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	0.3×D for side milling
Cutting width a_e for milling operation	Full slot cutting depth 1×D
Through-coolant	no
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		

