

Garant
Solid carbide roughing slot drill MTC, TiAlN, Ø d11 DC: 8mm

Order data

Order number	205711 8
GTIN	4045197541918
Item class	11X

Description
Version:

Dimensions similar to DIN 6527.

Optimised special knuckle profile for roughing.

Very **high rate of metal removal**.

With **semi-roughing knuckle profile** and 45° flutes for superalloys.

Application:

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

Note:

f_z for a_p max = $0.5 \times D$.

Technical description

Cutting edge Ø D _c	8 mm
Overhang length L ₁ incl. recess	26 mm
Feed f_z for slot milling in titanium > 850 N/mm ²	0.02 mm
Corner chamfer width at 45°	0.3 mm
Feed f_z for side milling in titanium > 850 N/mm ²	0.025 mm
No. of teeth Z	4
Recess Ø D ₁	7.5 mm
Shank Ø D _s	8 mm
Overall length L	64 mm
Flute length L _c	16 mm

Direction of infeed	horizontal, oblique and vertical
Shank	DIN 6535 HB to h6
Tolerance nominal \varnothing	d11
Helix angle	45 degrees
Corner chamfer angle	45 degrees
Coating	TiAlN
Tool material	Solid carbide
Standard	DIN 6527
Milling profile	HR
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	pink
Type of product	End / face mill

User data

	Suitability	V_c	ISO code
Steel < 500 N/mm ²	suitable	120 m/min	P
Steel < 750 N/mm ²	suitable	105 m/min	P
Steel < 900 N/mm ²	suitable	100 m/min	P
Steel < 1100 N/mm ²	suitable	70 m/min	P
Ti > 850 N/mm ²	suitable	50 m/min	S
GG(G)	suitable	90 m/min	K
wet maximum	suitable		
wet minimum	suitable only under restricted conditions		
dry	suitable only under restricted conditions		

Air

Suitable only under
restricted conditions