

**Garant**
**Solid carbide roughing slot drill MTC, TiAlN, Ø d11 DC: 20mm**

**Order data**

Order number	205711 20
GTIN	4045197541956
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**

Feed $f_z$ for side milling in titanium > 850 N/mm <sup>2</sup>	0.06 mm
No. of teeth Z	5
Overhang length $L_1$ incl. recess	54 mm
Cutting edge Ø $D_c$	20 mm
Recess Ø $D_1$	19.5 mm
Corner chamfer width at 45°	0.5 mm
Feed $f_z$ for slot milling in titanium > 850 N/mm <sup>2</sup>	0.055 mm
Shank Ø $D_s$	20 mm
Overall length L	104 mm
Flute length $L_c$	40 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 <sup>2</sup>	suitable	120 m/min	P
Steel < 750 N/mm <sup>2</sup>	suitable	105 m/min	P
Steel < 900 N/mm <sup>2</sup>	suitable	100 m/min	P
Steel < 1100 N/mm <sup>2</sup>	suitable	70 m/min	P
Ti > 850 N/mm <sup>2</sup>	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