Garant

Solid carbide roughing slot drill MTC, TiAlN, ⌀ d11 DC: 25mm

Order data

Order number	205711 25
GTIN	4045197541963
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×D.

Technical description

Overhang length L_1 incl. recess	65 mm
Recess ⌀ D_1	24 mm
Feed f_z for slot milling in titanium > 850 N/mm^2	0.055 mm
Feed f_z for side milling in titanium > 850 N/mm^2	0.06 mm
Corner chamfer width at 45°	0.5 mm
No. of teeth Z	5
Cutting edge ⌀ D_C	25 mm
Shank ⌀ D_s	25 mm
Overall length L	125 mm
Flute length L_c	50 mm

Direction of infeed	horizontal, oblique and vertical
Shank	DIN 6535 HB to h6
Tolerance nominal ∅	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/mm²	suitable	120 m/min	P
Steel < 750 N/mm²	suitable	105 m/min	P
Steel < 900 N/mm²	suitable	100 m/min	P
Steel < 1100 N/mm²	suitable	70 m/min	P
Ti > 850 N/mm²	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