



## Solid carbide roughing end mill MTC, TiAlN, Ø d11 DC: 8mm



### Order data

Order number	205715 8
GTIN	4045197549495
Item class	12X

### Description

#### Version:

Dimensions similar to DIN 6527. **Optimised special knuckle profile for roughing. Very high metal removal rate.**

#### Application:

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

### Technical description

Cutting edge Ø D <sub>c</sub>	8 mm
No. of teeth Z	4
Corner chamfer width at 45°	0.2 mm
Feed f <sub>z</sub> for slot milling in steel < 900 N/mm <sup>2</sup>	0.04 mm
Feed f <sub>z</sub> for side milling in steel < 900 N/mm <sup>2</sup>	0.05 mm
Shank Ø D <sub>s</sub>	8 mm
Overall length L	63 mm
Flute length L <sub>c</sub>	19 mm
Direction of infeed	horizontal, oblique and vertical
Shank	DIN 6535 HB to h6
Tolerance nominal Ø	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	0.5×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	green
Type of product	End / face mill

## User data

	Suitability	$V_c$	ISO code
Steel < 750 N/mm <sup>2</sup>	suitable	155 m/min	P
Steel < 900 N/mm <sup>2</sup>	suitable	155 m/min	P
Steel < 1100 N/mm <sup>2</sup>	suitable	125 m/min	P
Steel < 1400 N/mm <sup>2</sup>	suitable	110 m/min	P
INOX < 900 N/mm <sup>2</sup>	suitable	55 m/min	M
INOX > 900 N/mm <sup>2</sup>	suitable only under restricted conditions	40 m/min	M
GG(G)	suitable	110 m/min	K
Uni	suitable		
wet maximum	suitable		
wet minimum	suitable only under restricted conditions		
dry	suitable only under restricted conditions		
Air	Suitable only under restricted conditions		

