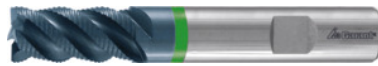


Garant

Roughing end mill MTC HSS-E-SPM, TiAlN, Ø k12 DC: 6mm



Order data

Order number	192895 6
GTIN	4045197359476
Item class	11W

Description

Version:

SPM substrate with very high cobalt content. Combines the **hardness of solid carbide** with the **toughness of PM steel**. **Dynamic special knuckle profile for roughing**.

For use as a universal roughing end mill Centre cutting edge geometry for plunging.

Application:

For very high metal removal rates and increased machining volumes. Especially for **MTC (Multi Task Cutting)** use on the new generation of turning / milling centres.

Technical description

Cutting edge $\varnothing D_c$	6 mm
No. of teeth Z	3
Corner chamfer width at 45°	0.2 mm
Feed f_z for side milling in steel < 1100 N/mm ²	0.014 mm
Shank $\varnothing D_s$	6 mm
Overall length L	57 mm
Flute length L_c	13 mm
Direction of infeed	horizontal, oblique and vertical
Shank	DIN 1835 B to h6
Tolerance nominal \varnothing	k12
Helix angle	45 degrees

Corner chamfer angle	45 degrees
Coating	TiAlN
Tool material	HSS E SPM
Standard	DIN 844
Milling profile	HRF
Through-coolant	no
Machining strategy	MTC
Colour ring	green
Type of product	End / face mill

User data

	Suitability	V _c	ISO code
Steel < 500 N/mm ²	suitable only under restricted conditions	95 m/min	P
Steel < 750 N/mm ²	suitable	75 m/min	P
Steel < 900 N/mm ²	suitable	75 m/min	P
Steel < 1100 N/mm ²	suitable	40 m/min	P
Steel < 1400 N/mm ²	suitable only under restricted conditions	35 m/min	P
INOX < 900 N/mm ²	suitable	25 m/min	M
INOX > 900 N/mm ²	suitable only under restricted conditions	20 m/min	M
Ti > 850 N/mm ²	suitable only under restricted conditions	14 m/min	S
Uni	suitable		
wet maximum	suitable		
wet minimum	suitable		
dry	suitable only under restricted conditions		
Air	suitable		

