

**Garant****Solid carbide milling cutter MTC, SiTiN, Ø f8 DC: 1mm****Order data**

Order number	202392 1
GTIN	4045197538697
Item class	11X

**Description****Version:****Special flute profile. Strengthened core.****MTC rough milling up to 1.5×D in solid material.****Eccentric relief ground.**Lengths similar to **DIN 6527 long.****Application:**Especially for **MTC (Multi Task Cutting)** use on the new generation of turning / milling centres.**Technical description**

Recess Ø D <sub>1</sub>	0.95 mm
No. of teeth Z	3
Cutting edge Ø D <sub>c</sub>	1 mm
Feed f <sub>z</sub> for slot milling in steel < 900 N/mm <sup>2</sup>	0.01 mm
Feed f <sub>z</sub> for side milling in steel < 900 N/mm <sup>2</sup>	0.012 mm
Overhang length L <sub>1</sub> incl. recess	5 mm
Shank Ø D <sub>s</sub>	6 mm
Overall length L	57 mm
Flute length L <sub>c</sub>	2.5 mm
Direction of infeed	horizontal, oblique and vertical
Shank	DIN 6535 HB to h6

## Data sheet

Tolerance nominal $\varnothing$	f8
Balance quality with shank	G 2.5 with HB
Helix angle	45 degrees
Corner chamfer angle	45 degrees
Coating	SiTiN
Tool material	Solid carbide
Standard	DIN 6527
Type	N
Helix angle characteristic	unequal spacing
Spacing of the cutters	unequal spacing
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 < 500 N/mm <sup>2</sup>	suitable	250 m/min	P
Steel < 750 N/mm <sup>2</sup>	suitable	220 m/min	P
Steel < 900 N/mm <sup>2</sup>	suitable	200 m/min	P
Steel < 1100 N/mm <sup>2</sup>	suitable	190 m/min	P
Steel < 1400 N/mm <sup>2</sup>	suitable	170 m/min	P
Steel < 55 HRC	suitable	90 m/min	H
Steel < 60 HRC	suitable	60 m/min	H
INOX < 900 N/mm <sup>2</sup>	suitable	130 m/min	M
INOX > 900 N/mm <sup>2</sup>	suitable	100 m/min	M

## Data sheet

Ti > 850 N/mm <sup>2</sup>	suitable only under restricted conditions	50 m/min	S
GG(G)	suitable	160 m/min	K
Uni	suitable		
wet maximum	suitable		
wet minimum	suitable only under restricted conditions		
dry	Suitable		
Air	Suitable		