

**Garant**
**Solid carbide milling cutter MTC, SiTiN, Ø f8 DC: 4mm**

**Order data**

Order number	202394 4
GTIN	4045197591586
Item class	11X

**Description**
**Version:**

**Special flute profile. Strengthened core.**

**MTC rough milling up to 1.5×D in solid material.**

**Eccentric relief ground.**

**Application:**

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

**Technical description**

Overhang length $L_1$ incl. recess	24 mm
Corner chamfer width at 45°	0.1 mm
Cutting edge $\varnothing D_c$	4 mm
Feed $f_z$ for slot milling in steel < 900 N/mm <sup>2</sup>	0.02 mm
Recess $\varnothing D_1$	3.9 mm
Feed $f_z$ for side milling in steel < 900 N/mm <sup>2</sup>	0.024 mm
No. of teeth Z	3
Shank $\varnothing D_s$	6 mm
Overall length L	62 mm
Flute length $L_c$	16 mm
Direction of infeed	horizontal, oblique and vertical
Shank	DIN 6535 HB to h6

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	Manufacturer's standard
Type	N
Helix angle characteristic	unequal spacing
Spacing of the cutters	unequal spacing
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	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

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		