Garant

Solid carbide milling cutter MTC, AlCrN, ∅ f8 DC: 7mm

Order data

Order number	202396 7
GTIN	4045197858146
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**.
Improved coating for a further reduction in cutting force combined with increased tool life.
Application:
Especially for **MTC (Multi Task Cutting)** use on the new generation of turning / milling centres.

Technical description

Overall length L	63 mm
Overhang length L_1 incl. recess	25 mm
Flute length L_c	19 mm
Tolerance nominal ∅	f8
No. of teeth Z	3
Recess ∅ D_1	6.8 mm
Feed f_z for slot milling in steel < 900 N/mm^2	0.04 mm
Corner chamfer width at 45°	0.2 mm
Feed f_z for side milling in steel < 900 N/mm^2	0.048 mm
Balance quality with shank	G 2.5 with HB
Shank	DIN 6535 HB to h6

Cutting edge ⌀ D_C	7 mm
Shank ⌀ D_s	8 mm
Direction of infeed	horizontal, oblique and vertical
Helix angle	45 degrees
Corner chamfer angle	45 degrees
Coating	AlCrN
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	Full slot cutting depth 1×D
Cutting width a_e for milling operation	0.5×D for side milling
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/mm²	suitable	250 m/min	P
Steel < 750 N/mm²	suitable	220 m/min	P
Steel < 900 N/mm²	suitable	200 m/min	P
Steel < 1100 N/mm²	suitable	190 m/min	P
Steel < 1400 N/mm²	suitable	170 m/min	P
Steel < 55 HRC	suitable	90 m/min	H
Steel < 60 HRC	suitable	60 m/min	H
INOX < 900 N/mm²	suitable	130 m/min	M
INOX > 900 N/mm²	suitable	100 m/min	M

Ti > 850 N/mm²	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		