

**Garant**
**Solid carbide milling cutter MTC, AlCrN, Ø f8 DC: 9mm**

**Order data**

Order number	202396 9
GTIN	4045197858184
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**

Feed $f_z$ for side milling in steel < 900 N/mm <sup>2</sup>	0.072 mm
Recess Ø $D_1$	8.7 mm
Feed $f_z$ for slot milling in steel < 900 N/mm <sup>2</sup>	0.06 mm
Flute length $L_c$	22 mm
Cutting edge Ø $D_c$	9 mm
Overall length $L$	72 mm
No. of teeth $Z$	3
Tolerance nominal Ø	f8
Balance quality with shank	G 2.5 with HB
Shank Ø $D_s$	10 mm
Overhang length $L_1$ incl. recess	30 mm

Corner chamfer width at 45°	0.2 mm
Direction of infeed	horizontal, oblique and vertical
Shank	DIN 6535 HB to h6
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/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		