

Garant
Solid carbide roughing end mill MTC / TPC, TiAlN, Ø f8 DC: 12 mm

Order data

Order number	202981 12
GTIN	4062406245481
Item class	11X

Description
Version:

Significant cutting force reduction due to 45° helix.

Specially for **trochoidal milling strategy**.

Application:

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

Note:

For materials > 55 HRC we recommend reducing the depth of cut to $a_p=0.25 \times D \dots 0.5 \times D$.

Tolerance nominal Ø: f8

No. of teeth Z: 4

Helix angle: 45 degrees

Direction of infeed: horizontal, oblique and vertical

Shank: DIN 6535 HB to h6

No. of teeth Z: 4

Flute length L_c : 36 mm

Overhang length L_1 incl. recess: 45 mm

Recess Ø D_1 : 11 mm

Overall length L: 93 mm

Shank Ø D_s : 12 mm

Technical description

Flute length L_c	36 mm
Shank Ø D_s	12 mm
Feed f_z for slot milling in steel < 60 HRC	0.03 mm
Overhang length L_1 incl. recess	45 mm

Cutting edge $\varnothing D_c$	12 mm
No. of teeth Z	4
Shank	DIN 6535 HB to h6
Overall length L	93 mm
Feed f_z for side milling in steel < 60 HRC	0.035 mm
Recess $\varnothing D_1$	11 mm
Tolerance nominal \varnothing	f8
Direction of infeed	horizontal, oblique and vertical
Helix angle	45 degrees
Corner rounding r_v	0.3 mm
Coating	TiAlN
Tool material	Solid carbide
Standard	Manufacturer's standard
Type	H
Helix angle characteristic	unequal spacing
Spacing of the cutters	unequal spacing
Cutting width a_e for milling operation	Full slot cutting depth $1 \times D$
Cutting width a_e for milling operation	$0.1 \times D$
Cutting width a_e for milling operation	$0.2 \times D$ for side milling
Through-coolant	no
Machining strategy	TPC
Machining strategy	MTC
Colour ring	red
Type of product	End mill

Services

Shank clamping flats for shrink-fit chucks, with retainer function Shank \varnothing tool 12 mm	SZ2025 12
Shank recess Type FRST	209900 FRST

