

Garant
Solid carbide roughing end mill MTC / TPC, TiAlN, Ø f8 DC: 4 mm

Order data

Order number	202981 4
GTIN	4062406245436
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 : 16 mm

Overhang length L_1 incl. recess: 23 mm

Recess Ø D_1 : 3.8 mm

Overall length L: 62 mm

Shank Ø D_s : 6 mm

Technical description

Overhang length L_1 incl. recess	23 mm
Helix angle	45 degrees
No. of teeth Z	4
Feed f_z for side milling in steel < 60 HRC	0.01 mm

Recess $\varnothing D_1$	3.8 mm
Tolerance nominal \varnothing	f8
Feed f_z for slot milling in steel < 60 HRC	0.008 mm
Cutting edge $\varnothing D_c$	4 mm
Shank	DIN 6535 HB to h6
Flute length L_c	16 mm
Overall length L	62 mm
Shank $\varnothing D_s$	6 mm
Direction of infeed	horizontal, oblique and vertical
Corner rounding r_v	0.1 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