

**Garant**
**Solid carbide roughing end mill MTC / TPC, TiAlN, Ø f8 DC: 6 mm**

**Order data**

Order number	202981 6
GTIN	4062406245450
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  $L_c$ : 18 mm

Overhang length  $L_1$  incl. recess: 25 mm

Recess Ø  $D_1$ : 5.5 mm

Overall length L: 62 mm

Shank Ø  $D_s$ : 6 mm

**Technical description**

No. of teeth Z	4
Feed $f_z$ for side milling in steel < 60 HRC	0.02 mm
Shank	DIN 6535 HB to h6
Recess Ø $D_1$	5.5 mm

Overall length L	62 mm
Tolerance nominal $\varnothing$	f8
Helix angle	45 degrees
Cutting edge $\varnothing D_c$	6 mm
Flute length $L_c$	18 mm
Shank $\varnothing D_s$	6 mm
Feed $f_z$ for slot milling in steel < 60 HRC	0.015 mm
Direction of infeed	horizontal, oblique and vertical
Overhang length $L_1$ incl. recess	25 mm
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

## Services

Shank recess Type FRST	209900 FRST
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