

## Garant

### Solid carbide roughing end mill MTC / TPC, TiAlN, Ø f8 DC: 14 mm



#### Order data

Order number	202978 14
GTIN	4045197431509
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 HA to h6

No. of teeth Z: 4

Flute length  $L_c$ : 42 mm

Overhang length  $L_1$  incl. recess: 50 mm

Recess Ø  $D_1$ : 13 mm

Overall length L: 99 mm

Shank Ø  $D_s$ : 14 mm

#### Technical description

Corner chamfer width at 45°	0.15 mm
No. of teeth Z	4
Feed $f_z$ for side milling in steel < 60 HRC	0.04 mm
Recess Ø $D_1$	13 mm

Overhang length $L_1$ incl. recess	50 mm
Cutting edge $\varnothing D_c$	14 mm
Feed $f_z$ for slot milling in steel < 60 HRC	0.05 mm
Shank $\varnothing D_s$	14 mm
Overall length L	99 mm
Flute length $L_c$	42 mm
Direction of infeed	horizontal, oblique and vertical
Shank	DIN 6535 HA to h6
Tolerance nominal $\varnothing$	f8
Helix angle	45 degrees
Corner chamfer angle	45 degrees
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	0.2×D for side milling
Cutting width $a_e$ for milling operation	Full slot cutting depth 1×D
Cutting width $a_e$ for milling operation	0.1×D
Through-coolant	no
Machining strategy	MTC
Machining strategy	TPC
Colour ring	red
Type of product	End mill

## Services

Shank recess Type FRST	209900 FRST
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