

Garant

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



Order data

Order number	202978 6
GTIN	4045197431455
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 : 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
Corner chamfer width at 45°	0.1 mm
Cutting edge Ø D_c	6 mm
Feed f_z for side milling in steel < 60 HRC	0.02 mm

Overhang length L_1 incl. recess	25 mm
Recess $\varnothing D_1$	5.5 mm
Feed f_z for slot milling in steel < 60 HRC	0.015 mm
Shank $\varnothing D_s$	6 mm
Overall length L	62 mm
Flute length L_c	18 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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