

**Garant**
**Solid carbide roughing end mill MTC, TiAlN, Ø d11 DC: 8mm**

**Order data**

Order number	205718 8
GTIN	4045197362889
Item class	11X

**Description**
**Version:**

Dimensions similar to DIN 6527.

**Optimised special knuckle profile for roughing.**

**Very high rate of metal removal.**

Can be used as a **universal end mill**.

**Application:**

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

**Technical description**

Cutting edge $\varnothing D_c$	8 mm
Overhang length $L_1$ incl. recess	50 mm
Recess $\varnothing D_1$	7.5 mm
Feed $f_z$ for side milling in steel $< 900 \text{ N/mm}^2$	0.04 mm
Corner chamfer width at $45^\circ$	0.2 mm
Feed $f_z$ for slot milling in steel $< 900 \text{ N/mm}^2$	0.03 mm
No. of teeth Z	4
Shank $\varnothing D_s$	8 mm
Overall length L	100 mm
Flute length $L_c$	16 mm
Direction of infeed	horizontal, oblique and vertical
Shank	DIN 6535 HB to h6

Tolerance nominal $\varnothing$	d11
Helix angle	45 degrees
Corner chamfer angle	45 degrees
Coating	TiAlN
Tool material	Solid carbide
Standard	Manufacturer's standard
Milling profile	HR
Cutting width $a_e$ for milling operation	0.1×D for side milling
Cutting width $a_e$ for milling operation	Full slot cutting depth 1×D
Through-coolant	no
Machining strategy	MTC
Colour ring	green
Type of product	End / face mill

## User data

	Suitability	$V_c$	ISO code
Steel < 500 N/mm <sup>2</sup>	suitable only under restricted conditions	120 m/min	P
Steel < 750 N/mm <sup>2</sup>	suitable	95 m/min	P
Steel < 900 N/mm <sup>2</sup>	suitable	85 m/min	P
Steel < 1100 N/mm <sup>2</sup>	suitable	80 m/min	P
Steel < 1400 N/mm <sup>2</sup>	suitable	70 m/min	P
TOOLOX 33	suitable	70 m/min	H
TOOLOX 44	suitable	60 m/min	H
INOX < 900 N/mm <sup>2</sup>	suitable only under restricted conditions	50 m/min	M
INOX > 900 N/mm <sup>2</sup>	suitable only under restricted conditions	35 m/min	M
GG(G)	suitable	70 m/min	K
Uni	suitable		

wet maximum	suitable
wet minimum	suitable only under restricted conditions
dry	suitable only under restricted conditions
Air	Suitable only under restricted conditions