

**Garant**
**Solid carbide milling cutter MTC, AlCrN, Ø f8 DC: 8mm**

**Order data**

Order number	202391 8
GTIN	4062406270865
Item class	11X

**Description**
**Version:**
**Special flute profile. Strengthened core.**
**MTC rough milling up to 1.5×D in solid material.**
**Eccentric relief ground.**

 Particularly sturdy due to short overall length. Overall length similar to **DIN 6527 short**.

**Application:**

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

**Technical description**

Corner chamfer width at 45°	0.15 mm
No. of teeth Z	3
Direction of infeed	horizontal, oblique and vertical
Feed $f_z$ for slot milling in steel < 900 N/mm <sup>2</sup>	0.04 mm
Helix angle	45 degrees
Cutting edge Ø $D_c$	8 mm
Shank	DIN 6535 HA to h6
Balance quality with shank	G 2.5 with HA
Overall length L	58 mm
Shank Ø $D_s$	8 mm
Tolerance nominal Ø	f8

Recess $\varnothing D_1$	7.8 mm
Feed $f_z$ for side milling in steel $< 900 \text{ N/mm}^2$	0.048 mm
Flute length $L_c$	12 mm
Overhang length $L_1$ incl. recess	20 mm
Corner chamfer angle	45 degrees
Coating	AlCrN
Tool material	Solid carbide
Standard	DIN 6527
Type	N
Helix angle characteristic	unequal spacing
Spacing of the cutters	unequal spacing
Cutting width $a_e$ for milling operation	Full slot cutting depth $1 \times D$
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Through-coolant	no
Machining strategy	MTC
Colour ring	green
Type of product	End / face mill

## User data

	Suitability	$V_c$	ISO code
Steel $< 500 \text{ N/mm}^2$	suitable	250 m/min	P
Steel $< 750 \text{ N/mm}^2$	suitable	220 m/min	P
Steel $< 900 \text{ N/mm}^2$	Suitable	200 m/min	P
Steel $< 1100 \text{ N/mm}^2$	Suitable	190 m/min	P
Steel $< 1400 \text{ N/mm}^2$	suitable	170 m/min	P
Steel $< 55 \text{ HRC}$	suitable	90 m/min	H
Steel $< 60 \text{ HRC}$	suitable	60 m/min	H
INOX $< 900 \text{ N/mm}^2$	suitable	130 m/min	M
INOX $> 900 \text{ N/mm}^2$	Suitable	100 m/min	M

Ti > 850 N/mm <sup>2</sup>	suitable only under restricted conditions	50 m/min	S
GG(G)	suitable	160 m/min	K
Uni	suitable		
wet maximum	Suitable		
wet minimum	suitable only under restricted conditions		
dry	Suitable		
Air	Suitable		