

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

Order data

Order number	205712 8
GTIN	4045197362674
Item class	11X

Description
Version:

Dimensions similar to DIN 6527.

Optimised special knuckle profile for roughing.

Very **high rate of metal removal**.

With **special internal tooth profile** and 50° flutes for reliable chip breaking in **stainless steels**.

Application:

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

Technical description

Feed f_z for slot milling in stainless steel $> 900 \text{ N/mm}^2$	0.022 mm
Cutting edge $\varnothing D_c$	8 mm
Corner chamfer width at 45°	0.2 mm
Overhang length L_1 incl. recess	26 mm
Recess $\varnothing D_1$	7.5 mm
Feed f_z for side milling in INOX $> 900 \text{ N/mm}^2$	0.03 mm
No. of teeth Z	4
Shank $\varnothing D_s$	8 mm
Overall length L	64 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	50 degrees
Corner chamfer angle	45 degrees
Coating	TiAlN
Tool material	Solid carbide
Standard	DIN 6527
Milling profile	HR
Cutting width a_e for milling operation	0.5×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	blue
Type of product	End / face mill

User data

	Suitability	V_c	ISO code
Steel < 500 N/mm ²	suitable	180 m/min	P
Steel < 750 N/mm ²	suitable	170 m/min	P
Steel < 900 N/mm ²	suitable	170 m/min	P
Steel < 1100 N/mm ²	suitable	140 m/min	P
INOX < 900 N/mm ²	suitable	100 m/min	M
INOX > 900 N/mm ²	suitable	80 m/min	M
wet maximum	suitable		
wet minimum	suitable only under restricted conditions		
dry	suitable only under restricted conditions		
Air	Suitable only under restricted conditions		

