



HARTMETALL ESTECH AG
Industriestrasse 13
6285 Hitzkirch
Telefon +41 (0)41 919 91 00
info.hartmetall@estech.ch
www.hartmetall-estech.ch

HARTMETALL ESTECH AG
Your specialist for T-slot milling cutters

NEW T-slot milling cutters made of 2 different carbide grades

> Until now, cemented carbide T-slot milling cutters had to be made of a medium hard carbide grade, to avoid the breaking-off of the cutting head from the shank during the milling process, as a result of shearing forces. Therefore, it was not always possible to select the carbide grade that would give the best cutting results in the material to be machined. This often led to a sub-optimal cutting performance and to a reduced lifetime of the tool.



Full-carbide standard T-slot milling cutters made of 1 carbide grade

- > Of course, we continue to manufacture our established standard T-slot milling cutters made in 1 piece of 1 carbide grade, as before. For these tools, our most common cemented carbide grade is RX10 for machining high- and low-alloyed steels, cast iron, titanium and many other materials.
- > We manufacture these cemented carbide blanks according to your specifications. The shanks can be delivered raw sintered with grinding allowance or finish ground to tolerances.
- > Try the quality of our cemented carbides and our short delivery times.
- > Please contact our technical sales consultants for further advice.



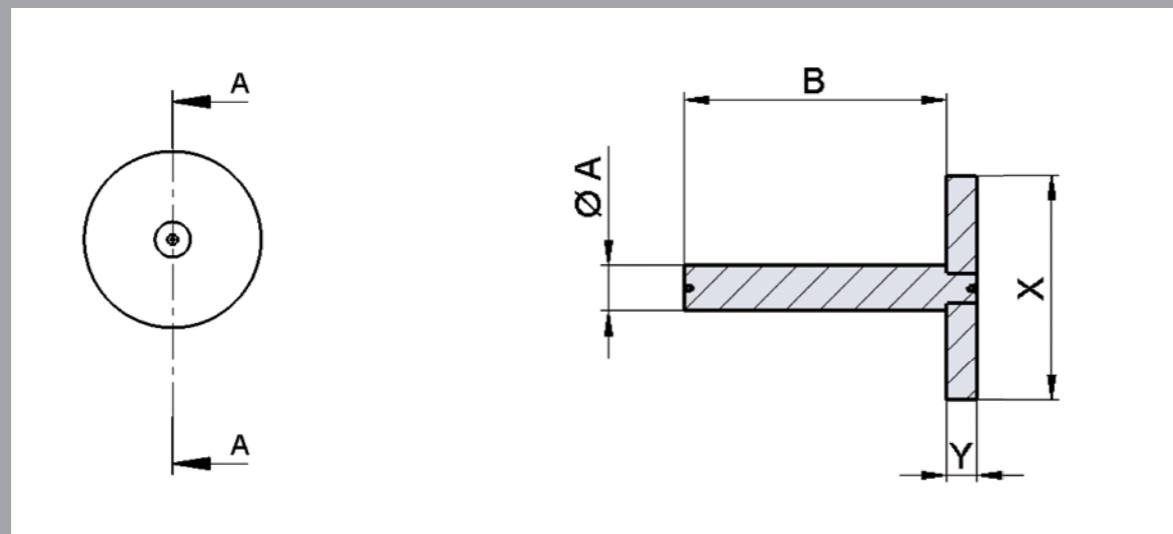


NEW

T-slot milling cutters made of 2 different carbide grades

> Hartmetall Estech AG brings a new solution!

By sintering together a cutting head, which is made of a hard, easy cutting and wear-resistant carbide grade, with a shank, which is made of a different tough and break-resistant carbide grade, we reach the best possible milling results at a low risk of breaking the tool.



> Example of application

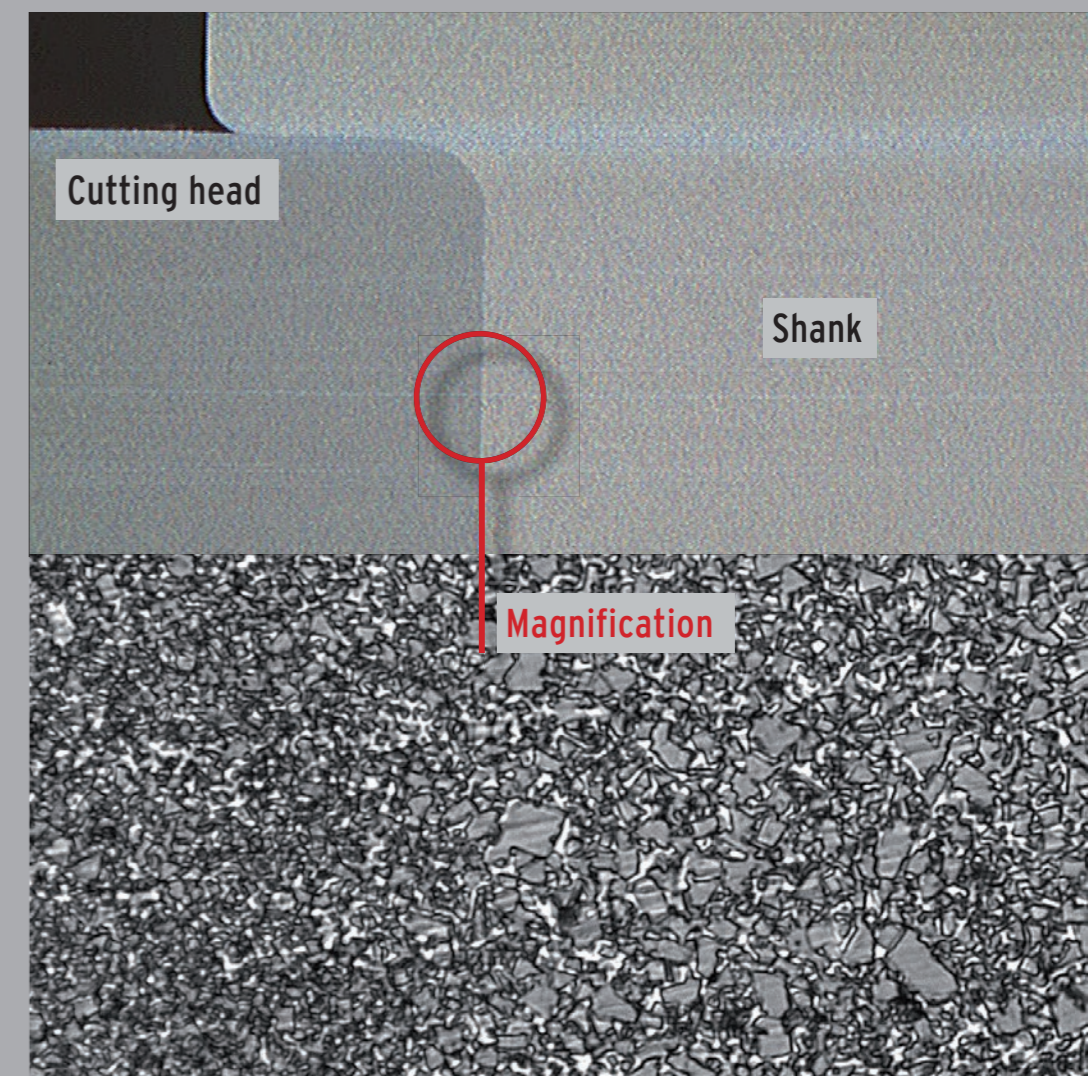
T-slot milling cutters for machining aluminium, copper, silver, graphite or glass-fibre reinforced plastics (GRP).

> Example

	Cemented carbide grade	Grain size μm	Cobalt content % w/w	Hardness HV30
Cutting head	RX7	submicron 0,8 μm	7.5 %	1720
Shank	RM22	medium 2,5 μm	11.0 %	1350

- > The cutting head is made of a hard cemented carbide grade to provide a good cutting ability, a low wear and a long tool life.
- > The cemented carbide shank consists of a tough material that accepts vibrations well and does not break during the use of the tool. It is much more rigid than a steel shank. Therefore, the T-slot milling cutter is well suited for high precision and high performance.
- > We manufacture our T-slot milling cutters in different material grades, head diameters and head widths, shank diameters and shank lengths.

> The two carbide grades RX7 (head) and RM22 (shank) are completely sintered together.



> Micro-structure along the boundary of the two carbide grades.