

Garant

Solid carbide milling cutter MTC, uncoated, Ø DC: 9,5mm



Order data

Order number	202244 9,5
GTIN	4062406127480
Item class	11X

Description

Version:

Eccentric relief ground, additionally **polish ground** in the flutes for **outstanding chip evacuation** in long-chipping aluminium workpieces.

Without 45° corner chamfer.

Without 45° corner chamfer.

Size 1–2 – tolerance: Size nominal Ø $D_c = e8$.

Size 2.5–20M – tolerance: Size nominal Ø $D_c = h6$.

Application:

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

Note:

NEW GENERATION AVAILABLE! Recommended successor product is No. 202002.

Technical description

Balance quality with shank	G 2.5 with HA
Tolerance nominal Ø	h6
Feed f_z for side milling in short-chipping aluminium	0.05 mm
Direction of infeed	horizontal, oblique and vertical
Recess Ø D_1	8.9 mm
Flute length L_c	22 mm
Overhang length L_1 incl. recess	30 mm
No. of teeth Z	3
Feed f_z for slot milling in short-chipping aluminium	0.04 mm

Cutting edge $\varnothing D_c$	9.5 mm
Shank $\varnothing D_s$	10 mm
Helix angle	45 degrees
Overall length L	72 mm
Shank	DIN 6535 HA to h6
Shank form	HA
Corner chamfer angle	90 degrees
Coating	uncoated
Tool material	Solid carbide
Standard	DIN 6527
Type	W
Helix angle characteristic	unequal spacing
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	yellow
Type of product	End / face mill

User data

	Suitability	V_c	ISO code
Aluminium	suitable	190 m/min	N
Aluminium (short chipping)	suitable	150 m/min	N
Alu > 10% Si	suitable	120 m/min	N
PMMA acrylic	suitable	180 m/min	N
PE-HD	Suitable	130 m/min	N
PA 66	Suitable	150 m/min	N
PEEK	suitable	130 m/min	N

PF 31	Suitable	110 m/min	N
Honeycomb sandwich	suitable only under restricted conditions	180 m/min	N
Cu	Suitable	120 m/min	N
CuZn	Suitable	150 m/min	N
wet maximum	suitable		
wet minimum	suitable		
dry	suitable only under restricted conditions		
Air	suitable only under restricted conditions		
Services			
Shank grinding Type HB		129100 HB	