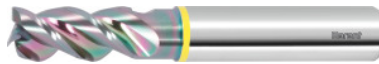


## Garant

### Solid carbide milling cutter MTC, DLC, Ø DC: 12Mmm



#### Order data

Order number	202270 12M
GTIN	4045197763952
Item class	11X

#### Description

##### Version:

With the latest generation of **DLC coating sp<sup>2</sup>**.

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

Lengths similar to **DIN 6527 long**.

##### Application:

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

##### Note:

**NEW GENERATION AVAILABLE!**

**Recommended successor products are No. 202004 and No. 202010.**

#### Technical description

No. of teeth Z	3
Corner chamfer width at 45°	0.2 mm
Tolerance nominal Ø	h6
Feed $f_z$ for side milling in short-chipping aluminium	0.07 mm
Overall length L	93 mm
Shank form	HA
Overhang length $L_1$ incl. recess	46 mm
Direction of infeed	horizontal, oblique and vertical
Shank Ø $D_s$	12 mm

Shank	DIN 6535 HA to h6
Balance quality with shank	G 2.5 with HA
Feed $f_z$ for slot milling in short-chipping aluminium	0.05 mm
Recess $\varnothing D_1$	11 mm
Cutting edge $\varnothing D_c$	12 mm
Flute length $L_c$	36 mm
Helix angle	45 degrees
Corner chamfer angle	45 degrees
Coating	DLC
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	480 m/min	N
Aluminium (short chipping)	suitable	440 m/min	N
Alu > 10% Si	suitable	400 m/min	N
PMMA acrylic	suitable	200 m/min	N
PE-HD	Suitable	160 m/min	N
PA 66	Suitable	200 m/min	N

PEEK	suitable	150 m/min	N
PF 31	Suitable	130 m/min	N
PVDF GF20	suitable	180 m/min	N
POM GF25	Suitable	160 m/min	N
PA 66 GF30	suitable	150 m/min	N
PEEK GF30	suitable	130 m/min	N
PTFE CF25	suitable	160 m/min	N
Honeycomb sandwich	suitable only under restricted conditions	300 m/min	N
Cu	Suitable	160 m/min	N
CuZn	Suitable	200 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