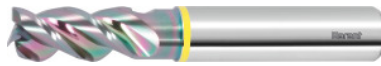


## Garant

### Solid carbide milling cutter MTC, DLC, Ø DC: 6Mmm



#### Order data

|              |               |
|--------------|---------------|
| Order number | 202272 6M     |
| GTIN         | 4045197763983 |
| 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.

**Without** 45° corner chamfer.

Lengths similar to **DIN 6527 long**.

Size 1–2 – tolerance: Size nominal Ø **D<sub>c</sub> = e8**.

Size 2.5–20M – tolerance: Size nominal Ø **D<sub>c</sub> = h6**.

##### 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 short-chipping aluminium | 0.025 mm                         |
| Cutting edge Ø $D_c$                                    | 6 mm                             |
| Direction of infeed                                     | horizontal, oblique and vertical |
| Flute length $L_c$                                      | 18 mm                            |
| Balance quality with shank                              | G 2.5 with HA                    |
| Shank Ø $D_s$   | 6 mm                             |
| Shank form  | HA                               |
| Overhang length $L_1$ incl. recess                      | 24 mm                            |
| Shank   | DIN 6535 HA to h6                |

|   |                             |
|---|-----------------------------|
| Tolerance nominal $\varnothing$                         | h6                          |
| Feed $f_z$ for side milling in short-chipping aluminium | 0.03 mm                     |
| Recess $\varnothing D_1$                                | 5.7 mm                      |
| No. of teeth Z  | 3                           |
| Overall length L  | 62 mm                       |
| Helix angle   | 45 degrees                  |
| Corner chamfer angle                                    | 90 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