

Garant
Solid carbide milling cutter TPC, DLC, Ø h6 DC: 6mm

Order data

| | |
|--------------|---------------|
| Order number | 202282 6 |
| GTIN | 4045197773227 |
| Item class | 11X |

Description
Version:

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

With double chip-breaker for exemplary chip formation.

With the latest generation of **DLC coating sp²**.

Note:

$a_{e \max} = 0.12 \times D$ for TPC machining.

h_{\max} : The values stated in the table are maximum values.

NEW GENERATION AVAILABLE! Recommended successor product is No. 203114.

Technical description

| | |
|-----------------------------|----------------------------------|
| Corner chamfer width at 45° | 0.2 mm |
| Balance quality with shank | G 2.5 with HA |
| Shank form | HA |
| Direction of infeed | horizontal, oblique and vertical |
| Tolerance nominal Ø | h6 |
| Overall length L | 71 mm |
| Shank | DIN 6535 HA to h6 |
| Shank Ø D _s | 6 mm |
| No. of teeth Z | 3 |
| Flute length L _c | 25 mm |

| | |
|--|-------------------------|
| Cutting edge $\varnothing D_c$ | 6 mm |
| Recess $\varnothing D_1$ | 5.7 mm |
| Overhang length L_1 incl. recess | 30 mm |
| Average chip thickness h_{max} for TPC milling in short-chipping aluminium | 0.032 mm |
| Helix angle | 45 degrees |
| Corner chamfer angle | 45 degrees |
| Coating | DLC |
| Tool material | Solid carbide |
| Standard | Manufacturer's standard |
| Type | W |
| Helix angle characteristic | unequal spacing |
| Cutting width a_e for milling operation | 0.12xD |
| Through-coolant | no |
| Machining strategy | TPC |
| Colour ring | yellow |
| Type of product | End / face mill |

User data

| | Suitability | V_c | ISO code |
|----------------------------|-------------|-----------|----------|
| Aluminium | Suitable | 280 m/min | N |
| Aluminium (short chipping) | suitable | 270 m/min | N |
| Alu > 10% Si | suitable | 180 m/min | N |
| PMMA acrylic | suitable | 125 m/min | N |
| PE-HD | Suitable | 110 m/min | N |
| PA 66 | Suitable | 140 m/min | N |
| PEEK | suitable | 90 m/min | N |
| PF 31 | Suitable | 80 m/min | N |

| | | | |
|--------------------|---|-----------|---|
| PVDF GF20 | suitable | 125 m/min | N |
| POM GF25 | Suitable | 115 m/min | N |
| PA 66 GF30 | suitable | 105 m/min | N |
| PEEK GF30 | suitable | 90 m/min | N |
| PTFE CF25 | suitable | 110 m/min | N |
| Honeycomb sandwich | suitable only under restricted conditions | 120 m/min | N |
| Cu | Suitable | 80 m/min | N |
| CuZn | Suitable | 100 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