

**Garant**
**Solid carbide milling cutter MTC, uncoated, Ø DC: 8,5mm**

**Order data**

Order number	202244 8,5
GTIN	4045197654755
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.

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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**

Feed $f_z$ for side milling in short-chipping aluminium	0.04 mm
Cutting edge Ø $D_c$	8.5 mm
Feed $f_z$ for slot milling in short-chipping aluminium	0.03 mm
No. of teeth Z	3
Overhang length $L_1$ incl. recess	30 mm
Recess Ø $D_1$	7.9 mm
Shank form	HA
Shank Ø $D_s$	10 mm
Overall length L	72 mm

Flute length $L_c$	22 mm
Direction of infeed	horizontal, oblique and vertical
Shank	DIN 6535 HA to h6
Tolerance nominal $\varnothing$	h6
Balance quality with shank	G 2.5 with HA
Helix angle	45 degrees
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		
<b>Services</b>			
Shank grinding Type HB			129100 HB