

**Garant**
**Solid carbide milling cutter MTC, uncoated, Ø h6 DC: 4mm**

**Order data**

Order number	202247 4
GTIN	4045197571021
Item class	11X

**Description**
**Version:**

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

**Application:**

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

**Technical description**

No. of teeth Z	3
Feed $f_z$ for slot milling in short-chipping aluminium	0.015 mm
Corner chamfer width at 45°	0.1 mm
Overhang length $L_1$ incl. recess	24 mm
Cutting edge Ø $D_c$	4 mm
Feed $f_z$ for side milling in short-chipping aluminium	0.02 mm
Shank form	HA
Recess Ø $D_1$	3.7 mm
Shank Ø $D_s$	6 mm
Overall length L	80 mm
Flute length $L_c$	6.5 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	45 degrees
Coating	uncoated
Tool material	Solid carbide
Standard	Manufacturer's standard
Type	W
Helix angle characteristic	unequal spacing
Cutting width $a_e$ for milling operation	0.3×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	130 m/min	N
Aluminium (short chipping)	suitable	100 m/min	N
Alu > 10% Si	suitable	85 m/min	N
PMMA acrylic	suitable	140 m/min	N
PE-HD	Suitable	100 m/min	N
PA 66	Suitable	110 m/min	N
PEEK	suitable	100 m/min	N
PF 31	Suitable	85 m/min	N
Honeycomb sandwich	suitable only under restricted conditions	100 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