

Garant

Solid carbide milling cutter MTC, uncoated, \varnothing h6 DC: 12mm



Order data

| | |
|--------------|---------------|
| Order number | 202247 12 |
| GTIN | 4045197571069 |
| 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

| | |
|---|----------------------------------|
| Overhang length L_1 incl. recess | 73 mm |
| Feed f_z for slot milling in short-chipping aluminium | 0.05 mm |
| Cutting edge $\varnothing D_c$ | 12 mm |
| Recess $\varnothing D_1$ | 11 mm |
| Feed f_z for side milling in short-chipping aluminium | 0.07 mm |
| No. of teeth Z | 3 |
| Corner chamfer width at 45° | 0.2 mm |
| Shank form | HA |
| Shank $\varnothing D_s$ | 12 mm |
| Overall length L | 120 mm |
| Flute length L_c | 19 mm |
| Direction of infeed | horizontal, oblique and vertical |
| Shank | DIN 6535 HA to h6 |

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|---|-----------------------------|
| 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