

Garant

Solid carbide milling cutter with internal coolant supply MTC, uncoated, Ø DC: 8mm



Order data

| | |
|--------------|---------------|
| Order number | 202249 8 |
| GTIN | 4045197657329 |
| Item class | 11X |

Description

Version:

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

Lengths similar to **DIN 6527 long**.

Application:

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

Technical description

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|---|---------|
| Recess $\varnothing D_1$ | 7.4 mm |
| Corner chamfer width at 45° | 0.2 mm |
| Feed f_z for slot milling in short-chipping aluminium | 0.03 mm |
| Overhang length L_1 incl. recess | 25 mm |
| Cutting edge $\varnothing D_c$ | 8 mm |
| No. of teeth Z | 3 |
| Shank form | HA |
| Feed f_z for side milling in short-chipping aluminium | 0.04 mm |
| Shank $\varnothing D_s$ | 8 mm |
| Overall length L | 63 mm |
| Flute length L_c | 21 mm |

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|---|----------------------------------|
| 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 | 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 | yes |
| 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 | | |

Services

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|------------------------|-----------|
| Shank grinding Type HB | 129100 HB |
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