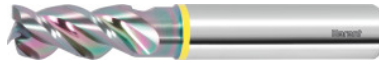


## Garant

### Solid carbide milling cutter MTC, DLC, Ø DC: 4mm



## Order data

|              |               |
|--------------|---------------|
| Order number | 202270 4      |
| GTIN         | 4045197654939 |
| Item class   | 11X           |

## Description

### Version:

With the latest generation of **DLC coating sp<sup>2</sup>**.

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

Lengths similar to **DIN 6527 long**.

### Application:

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

### Note:

**NEW GENERATION AVAILABLE!**

**Recommended successor products are No. 202004 and No. 202010.**

## Technical description

|   |          |
|---|----------|
| Corner chamfer width at 45°                             | 0.1 mm   |
| No. of teeth Z  | 3        |
| Feed $f_z$ for slot milling in short-chipping aluminium | 0.015 mm |
| Overhang length $L_1$ incl. recess                      | 17 mm    |
| Recess $\varnothing D_1$                                | 3.7 mm   |
| Shank form  | HA       |
| Feed $f_z$ for side milling in short-chipping aluminium | 0.02 mm  |
| Cutting edge $\varnothing D_c$                          | 4 mm     |
| Shank $\varnothing D_s$                                 | 6 mm     |

|  |                                  |
|--|----------------------------------|
| Overall length L                                   | 57 mm                            |
| Flute length L <sub>c</sub>                        | 11 mm                            |
| Direction of infeed                                | horizontal, oblique and vertical |
| Shank  | DIN 6535 HA to h6                |
| Tolerance nominal Ø                                | h6                               |
| Balance quality with shank                         | G 2.5 with HA                    |
| Helix angle  | 45 degrees                       |
| Corner chamfer angle                               | 45 degrees                       |
| Coating  | DLC                              |
| Tool material                                      | Solid carbide                    |
| Standard   | DIN 6527                         |
| Type   | W                                |
| Helix angle characteristic                         | unequal spacing                  |
| Cutting width a <sub>e</sub> for milling operation | 0.5×D for side milling           |
| Cutting width a <sub>e</sub> 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 <sub>c</sub> | ISO code |
|----------------------------|-------------|----------------|----------|
| Aluminium                  | suitable    | 480 m/min      | N        |
| Aluminium (short chipping) | suitable    | 440 m/min      | N        |
| Alu > 10% Si               | suitable    | 400 m/min      | N        |
| PMMA acrylic               | suitable    | 200 m/min      | N        |
| PE-HD                      | Suitable    | 160 m/min      | N        |
| PA 66                      | Suitable    | 200 m/min      | N        |

|                    |   |           |   |
|--------------------|---|-----------|---|
| PEEK               | suitable                                  | 150 m/min | N |
| PF 31              | Suitable                                  | 130 m/min | N |
| PVDF GF20          | suitable                                  | 180 m/min | N |
| POM GF25           | Suitable                                  | 160 m/min | N |
| PA 66 GF30         | suitable                                  | 150 m/min | N |
| PEEK GF30          | suitable                                  | 130 m/min | N |
| PTFE CF25          | suitable                                  | 160 m/min | N |
| Honeycomb sandwich | suitable only under restricted conditions | 300 m/min | N |
| Cu                 | Suitable                                  | 160 m/min | N |
| CuZn               | Suitable                                  | 200 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