

Garant
Solid carbide milling cutter MTC, DLC, Ø h6 DC: 20mm

Order data

Order number	202274 20
GTIN	4045197655134
Item class	11X

Description
Version:

With the latest generation of **DLC coating sp²**.

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

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. 202017.

Technical description

Shank form	HB
Feed f_z for side milling in short-chipping aluminium	0.12 mm
Corner chamfer width at 45°	0.2 mm
Overhang length L_1 incl. recess	98 mm
No. of teeth Z	3
Cutting edge $\varnothing D_c$	20 mm
Recess $\varnothing D_1$	19 mm
Feed f_z for slot milling in short-chipping aluminium	0.085 mm
Shank $\varnothing D_s$	20 mm
Overall length L	150 mm

Flute length L_c	32 mm
Direction of infeed	horizontal, oblique and vertical
Shank	DIN 6535 HB to h6
Tolerance nominal \varnothing	h6
Balance quality with shank	G 2.5 with HB
Helix angle	45 degrees
Corner chamfer angle	45 degrees
Coating	DLC
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	440 m/min	N
Aluminium (short chipping)	suitable	400 m/min	N
Alu > 10% Si	suitable	360 m/min	N
PMMA acrylic	suitable	180 m/min	N
PE-HD	Suitable	150 m/min	N
PA 66	Suitable	180 m/min	N
PEEK	suitable	140 m/min	N

PF 31	Suitable	120 m/min	N
PVDF GF20	suitable	170 m/min	N
POM GF25	Suitable	150 m/min	N
PA 66 GF30	suitable	140 m/min	N
PEEK GF30	suitable	120 m/min	N
PTFE CF25	suitable	150 m/min	N
Honeycomb sandwich	suitable only under restricted conditions	280 m/min	N
Cu	Suitable	150 m/min	N
CuZn	Suitable	190 m/min	N
wet maximum	suitable		
wet minimum	suitable		
dry	suitable only under restricted conditions		
Air	suitable only under restricted conditions		