

## Garant

### Solid carbide milling cutter MTC, DLC, Ø h6 DC: 6mm



#### Order data

|              |               |
|--------------|---------------|
| Order number | 202273 6      |
| GTIN         | 4045197854827 |
| 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.

**Without** 45° cutting edge chamfer.

##### Application:

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

#### Technical description

|   |                                  |
|---|----------------------------------|
| Feed $f_z$ for side milling in short-chipping aluminium | 0.03 mm                          |
| No. of teeth Z  | 3                                |
| Recess $\varnothing D_1$                                | 5.7 mm                           |
| Direction of infeed                                     | horizontal, oblique and vertical |
| Cutting edge $\varnothing D_c$                          | 6 mm                             |
| Shank form  | HA                               |
| Tolerance nominal $\varnothing$                         | h6                               |
| Shank $\varnothing D_s$                                 | 6 mm                             |
| Shank   | DIN 6535 HA to h6                |
| Feed $f_z$ for slot milling in short-chipping aluminium | 0.025 mm                         |
| Flute length $L_c$                                      | 13 mm                            |

|   |                                      |
|---|--------------------------------------|
| Overhang length $L_1$ incl. recess        | 24 mm                                |
| Overall length L                          | 62 mm                                |
| Balance quality with shank                | G 2.5 with HA                        |
| Helix angle                               | 45 degrees                           |
| Corner chamfer angle                      | 90 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 | Full slot cutting depth $1 \times D$ |
| Cutting width $a_e$ for milling operation | $0.5 \times D$ for side milling      |
| Through-coolant                           | no                                   |
| Machining strategy                        | MTC                                  |
| Colour ring                               | yellow                               |
| Type of product                           | End / face mill                      |

## User data

|                            | Suitability | $V_c$     | 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