Garant

Solid carbide milling cutter MTC, uncoated, ∅ h6 DC: 20mm

Order data

Order number	202257 20
GTIN	4045197860101
Item class	11X

Description

Version:
Eccentric relief ground, additionally **polish ground** in the flutes for **outstanding chip evacuation** in long-chipping aluminium workpieces.
Without 45° corner chamfer.
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. 202012.

Technical description

Direction of infeed	horizontal, oblique and vertical
Flute length L_c	41 mm
Balance quality with shank	G 2.5 with HB
Shank form	HB
No. of teeth Z	3
Feed f_z for side milling in short-chipping aluminium	0.12 mm
Tolerance nominal ∅	h6
Recess ∅ D_1	19 mm
Overall length L	126 mm
Feed f_z for slot milling in short-chipping aluminium	0.085 mm

Shank ⌀ D_s	20 mm
Shank	DIN 6535 HB to h6
Overhang length L_1 incl. recess	74 mm
Cutting edge ⌀ D_C	20 mm
Helix angle	45 degrees
Corner chamfer angle	90 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	Full slot cutting depth 1×D
Cutting width a_e for milling operation	0.5×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	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		