

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

**Order data**

|              |               |
|--------------|---------------|
| Order number | 202273 20     |
| GTIN         | 4045197860200 |
| 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**

|  |                                  |
|--|----------------------------------|
| Shank Ø D <sub>s</sub>   | 20 mm                            |
| Feed f <sub>z</sub> for side milling in short-chipping aluminium | 0.12 mm                          |
| Shank  | DIN 6535 HB to h6                |
| Balance quality with shank                                       | G 2.5 with HB                    |
| No. of teeth Z   | 3                                |
| Shank form   | HB                               |
| Flute length L <sub>c</sub>                                      | 41 mm                            |
| Feed f <sub>z</sub> for slot milling in short-chipping aluminium | 0.085 mm                         |
| Recess Ø D <sub>1</sub>  | 19 mm                            |
| Overhang length L <sub>1</sub> incl. recess                      | 74 mm                            |
| Direction of infeed  | horizontal, oblique and vertical |

|   |                                      |
|---|--------------------------------------|
| Tolerance nominal $\varnothing$           | h6                                   |
| Overall length L                          | 126 mm                               |
| Cutting edge $\varnothing D_c$            | 20 mm                                |
| 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 |           |   |