

Garant

Solid carbide milling cutter MTC, uncoated, Ø DC: 1mm



Order data

Order number	202244 1
GTIN	4045197858061
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.

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Size 1–2 – tolerance: Size nominal Ø D_c = **e8**.

Size 2.5–20M – tolerance: Size nominal Ø D_c = **h6**.

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. 202002.

Tolerance nominal Ø: e8

No. of teeth Z: 3

Helix angle: 45°

Direction of infeed: horizontal, oblique and vertical

Shank: DIN 6535 HA to h6

Balance quality with shank: G 2.5 with HA

No. of teeth Z: 3

Flute length L_c : 2.5 mm

Overhang length L_1 incl. recess: 5 mm

Recess Ø D_1 : 0.95 mm

Overall length L: 57 mm

Shank Ø D_s : 6 mm

Technical description

Tolerance nominal Ø	e8
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Feed f_z for slot milling in short-chipping aluminium	0.005 mm
Balance quality with shank	G 2.5 with HA
Flute length L_c	2.5 mm
Shank $\varnothing D_s$	6 mm
Recess $\varnothing D_1$	0.95 mm
Direction of infeed	horizontal, oblique and vertical
Overall length L	57 mm
Cutting edge $\varnothing D_c$	1 mm
Overhang length L_1 incl. recess	5 mm
Shank form	HA
Feed f_z for side milling in short-chipping aluminium	0.008 mm
No. of teeth Z	3
Shank	DIN 6535 HA to h6
Helix angle	45 °
Corner chamfer angle	90 °
Coating	uncoated
Tool material	Solid carbide
Standard	DIN 6527
Type	W
Helix angle characteristic	unequal spacing
Cutting width a_e for milling operation	0.5×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
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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		

Services

Shank grinding Type HB

129100 HB