

## Garant

### Solid carbide milling cutter MTC, uncoated, Ø DC: 2mm



#### Order data

Order number	202244 2
GTIN	4045197858085
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.**

#### Technical description

Balance quality with shank	G 2.5 with HA
Recess Ø $D_1$	1.92 mm
Cutting edge Ø $D_c$	2 mm
Shank Ø $D_s$	6 mm
Overall length L	57 mm
Tolerance nominal Ø	e8
Direction of infeed	horizontal, oblique and vertical
Shank	DIN 6535 HA to h6
Flute length $L_c$	5 mm

Feed $f_z$ for slot milling in short-chipping aluminium	0.006 mm
Overhang length $L_1$ incl. recess	10 mm
No. of teeth Z	3
Feed $f_z$ for side milling in short-chipping aluminium	0.009 mm
Shank form	HA
Helix angle	45 degrees
Corner chamfer angle	90 degrees
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
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		
<b>Services</b>			
Shank grinding Type HB		129100 HB	