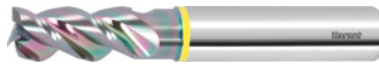


**Garant**
**Solid carbide milling cutter MTC, DLC, Ø DC: 3,5mm**

**Order data**

Order number	202270 3,5
GTIN	4045197861016
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.

Lengths similar to **DIN 6527 long**.

**Application:**

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

**Note:**

**NEW GENERATION AVAILABLE!**

**Recommended successor products are No. 202004 and No. 202010.**

**Technical description**

Shank	DIN 6535 HA to h6
Shank form	HA
Shank Ø D <sub>s</sub>	6 mm
Recess Ø D <sub>1</sub>	3.2 mm
Cutting edge Ø D <sub>c</sub>	3.5 mm
No. of teeth Z	3
Flute length L <sub>c</sub>	11 mm
Overall length L	57 mm
Corner chamfer width at 45°	0.1 mm

Direction of infeed	horizontal, oblique and vertical
Tolerance nominal $\varnothing$	h6
Overhang length $L_1$ incl. recess	17 mm
Helix angle	45 degrees
Corner chamfer angle	45 degrees
Coating	DLC
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	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