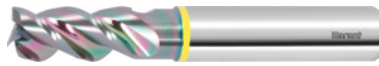


Garant
Solid carbide milling cutter MTC, DLC, Ø DC: 14mm

Order data

Order number	202270 14
GTIN	4045197861054
Item class	11X

Description
Version:

With the latest generation of **DLC coating sp²**.

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

Corner chamfer width at 45°	0.2 mm
Recess Ø D ₁	13 mm
Shank	DIN 6535 HA to h6
Feed f _z for slot milling in short-chipping aluminium	0.05 mm
Tolerance nominal Ø	h6
Shank form	HA
Cutting edge Ø D _c	14 mm
Shank Ø D _s	14 mm
Flute length L _c	26 mm

Overhang length L_1 incl. recess	36 mm
Feed f_z for side milling in short-chipping aluminium	0.07 mm
Overall length L	83 mm
No. of teeth Z	3
Direction of infeed	horizontal, oblique and vertical
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		