

Garant**Solid carbide milling cutter TPC, DLC, Ø h6 DC: 6mm****Order data**

Order number	202284 6
GTIN	4045197977281
Item class	11X

Description**Version:**

Eccentric relief ground, additionally **polish ground** in the flutes for **outstanding chip evacuation** in long-chipping aluminium workpieces.

With double chip-breaker for exemplary chip formation.

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

Note:

NEW GENERATION AVAILABLE! Recommended successor product is No. 203115.

$a_{e\ max} = 0.1 \times D$ for TPC machining.

h_{max} : The values stated in the table are maximum values.

Technical description

Shank	DIN 6535 HA to h6
Shank form	HA
Flute length L_c	31 mm
Overhang length L_1 incl. recess	36 mm
Cutting edge $\varnothing D_c$	6 mm
Direction of infeed	horizontal, oblique and vertical
Overall length L	76 mm
Shank $\varnothing D_s$	6 mm
Recess $\varnothing D_1$	5.7 mm
Helix angle	45 degrees

Average chip thickness h_{\max} for TPC milling in short-chipping aluminium	0.027 mm
No. of teeth Z	3
Corner chamfer width at 45°	0.2 mm
Tolerance nominal Ø	h6
Balance quality with shank	G 2.5 with HA
Corner chamfer angle	45 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	0.1×D
Through-coolant	no
Machining strategy	TPC
Colour ring	yellow
Type of product	End / face mill

User data

	Suitability	V_c	ISO code
Aluminium	Suitable	280 m/min	N
Aluminium (short chipping)	suitable	270 m/min	N
Alu > 10% Si	suitable	180 m/min	N
PMMA acrylic	suitable	125 m/min	N
PE-HD	Suitable	110 m/min	N
PA 66	Suitable	140 m/min	N
PEEK	suitable	90 m/min	N
PF 31	Suitable	80 m/min	N

PVDF GF20	suitable	125 m/min	N
POM GF25	Suitable	115 m/min	N
PA 66 GF30	suitable	105 m/min	N
PEEK GF30	suitable	90 m/min	N
PTFE CF25	suitable	110 m/min	N
Honeycomb sandwich	suitable only under restricted conditions	120 m/min	N
Cu	Suitable	80 m/min	N
CuZn	Suitable	100 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