

Garant

Solid carbide milling cutter with internal coolant supply MTC, uncoated, Ø DC: 6mm

**Order data**

Order number	202249 6
GTIN	4045197657312
Item class	11X

Description**Version:**

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

Lengths similar to **DIN 6527 long**.

Application:

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

Technical description

Recess Ø D ₁	5.7 mm
Overhang length L ₁ incl. recess	19 mm
Feed f _z for side milling in short-chipping aluminium	0.03 mm
Feed f _z for slot milling in short-chipping aluminium	0.025 mm
Corner chamfer width at 45°	0.2 mm
No. of teeth Z	3
Shank form	HA
Cutting edge Ø D _c	6 mm
Shank Ø D _s	6 mm
Overall length L	57 mm
Flute length L _c	13 mm

Direction of infeed	horizontal, oblique and vertical
Shank	DIN 6535 HA to h6
Tolerance nominal Ø	h6
Balance quality with shank	G 2.5 with HA
Helix angle	45 degrees
Corner chamfer angle	45 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	yes
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		
Services			

Shank grinding Type HB	129100 HB
------------------------	-----------