

## Garant

### Solid carbide milling cutter MTC, uncoated, Ø h6 DC: 20mm



#### Order data

Order number	202256 20
GTIN	4045197860057
Item class	11X

#### Description

##### Version:

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

##### Application:

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

#### Technical description

Feed $f_z$ for side milling in short-chipping aluminium	0.12 mm
Direction of infeed	horizontal, oblique and vertical
Flute length $L_c$	41 mm
Overall length $L$	126 mm
Recess $\varnothing D_1$	19 mm
Balance quality with shank	G 2.5 with HB
Corner chamfer width at 45°	0.2 mm
Overhang length $L_1$ incl. recess	74 mm
Shank form	HB
No. of teeth $Z$	3
Shank $\varnothing D_s$	20 mm
Shank	DIN 6535 HB to h6
Tolerance nominal $\varnothing$	h6

Feed $f_z$ for slot milling in short-chipping aluminium	0.085 mm
Cutting edge $\varnothing D_c$	20 mm
Helix angle	45 degrees
Corner chamfer angle	45 degrees
Coating	uncoated
Tool material	Solid carbide
Standard	Manufacturer's standard
Type	W
Helix angle characteristic	unequal spacing
Cutting width $a_e$ for milling operation	Full slot cutting depth $1 \times D$
Cutting width $a_e$ for milling operation	$0.5 \times D$ for side milling
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		