

Garant

Solid carbide milling cutter MTC, DLC, Ø DC: 20mm



Order data

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| Order number | 202272 20 |
| GTIN | 4045197655066 |
| 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.

Without 45° corner chamfer.

Lengths similar to **DIN 6527 long**.

Size 1–2 – tolerance: Size nominal Ø $D_c = e8$.

Size 2.5–20M – tolerance: Size nominal Ø $D_c = h6$.

Application:

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

Tolerance nominal Ø: h6

No. of teeth Z: 3

Helix angle: 45°

Direction of infeed: horizontal, oblique and vertical

Shank: DIN 6535 HB to h6

Balance quality with shank: G 2.5 with HB

No. of teeth Z: 3

Flute length L_c : 41 mm

Overhang length L_1 incl. recess: 52 mm

Recess Ø D_1 : 19 mm

Overall length L: 104 mm

Shank Ø D_s : 20 mm

Technical description

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|------------------------------------|-------|
| Overhang length L_1 incl. recess | 52 mm |
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|---|----------------------------------|
| No. of teeth Z | 3 |
| Shank form | HB |
| Recess $\varnothing D_1$ | 19 mm |
| Feed f_z for slot milling in short-chipping aluminium | 0.085 mm |
| Cutting edge $\varnothing D_c$ | 20 mm |
| Feed f_z for side milling in short-chipping aluminium | 0.12 mm |
| Shank $\varnothing D_s$ | 20 mm |
| Overall length L | 104 mm |
| Flute length L_c | 41 mm |
| Direction of infeed | horizontal, oblique and vertical |
| Shank | DIN 6535 HB to h6 |
| Tolerance nominal \varnothing | h6 |
| Balance quality with shank | G 2.5 with HB |
| Helix angle | 45 ° |
| Corner chamfer angle | 90 ° |
| 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 |
|--|-------------|-------|----------|
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| 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

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| Shank recess Type FRST | 209900 FRST |
| Shank clamping flats for shrink-fit chucks, with retainer function Shank Ø tool 20 mm | SZ2025 20 |