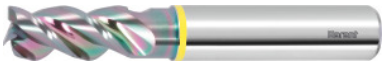
Garant

Solid carbide milling cutter MTC, DLC, ∅ DC: 6mm



Order data

Order number	202272 6
GTIN	4045197655011
Item class	11X

Description

Version:
With the latest generation of **DLC coating sp**^{2}.
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 ∅ **D_C = e8.**
Size 2.5–20M – tolerance: Size nominal ∅ **D_C = h6.**
Application:
Especially for **MTC (Multi Task Cutting)** use on the new generation of turning / milling centres.
Tolerance nominal ∅: h6
No. of teeth Z: 3
Helix angle: 45 °
Direction of infeed: horizontal, oblique and vertical
Shank: DIN 6535 HA to h6
Balance quality with shank: G 2.5 with HA
No. of teeth Z: 3
Flute length L_c: 13 mm
Overhang length L_1 incl. recess: 19 mm
Recess ∅ D_1: 5.7 mm
Overall length L: 57 mm
Shank ∅ D_s: 6 mm

Technical description

Feed f_z for slot milling in short-chipping aluminium	0.025 mm

Cutting edge ∅ D_C	6 mm
Shank form	HA
Feed f_z for side milling in short-chipping aluminium	0.03 mm
No. of teeth Z	3
Recess ∅ D_1	5.7 mm
Overhang length L_1 incl. recess	19 mm
Shank ∅ 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 ∅	h6
Balance quality with shank	G 2.5 with HA
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

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

Shank recess Type FRST	209900 FRST
Shank grinding Type HB	129100 HB