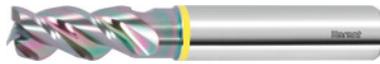


**Garant**
**Solid carbide milling cutter MTC, DLC, Ø DC: 1,5mm**

**Order data**

Order number	202272 1,5
GTIN	4045197861108
Item class	11X

**Description**
**Version:**

With the latest generation of **DLC coating sp<sup>2</sup>**.

**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<sub>c</sub> = e8**.

Size 2.5–20M – tolerance: Size nominal Ø **D<sub>c</sub> = h6**.

**Application:**

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

Tolerance nominal Ø: e8

No. of teeth Z: 3

Helix angle: 45 °

Direction of infeed: horizontal, oblique and vertical

Shank: DIN 6535 HA to h6

No. of teeth Z: 3

Flute length L<sub>c</sub>: 4 mm

Overhang length L<sub>1</sub> incl. recess: 7.5 mm

Recess Ø D<sub>1</sub>: 1.44 mm

Overall length L: 57 mm

Shank Ø D<sub>s</sub>: 6 mm

**Technical description**

Recess Ø D <sub>1</sub>	1.44 mm
Overall length L	57 mm

Shank	DIN 6535 HA to h6
Shank $\varnothing D_s$	6 mm
No. of teeth Z	3
Shank form	HA
Feed $f_z$ for side milling in short-chipping aluminium	0.008 mm
Direction of infeed	horizontal, oblique and vertical
Tolerance nominal $\varnothing$	e8
Cutting edge $\varnothing D_c$	1.5 mm
Flute length $L_c$	4 mm
Feed $f_z$ for slot milling in short-chipping aluminium	0.005 mm
Overhang length $L_1$ incl. recess	7.5 mm
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 grinding Type HB

129100 HB