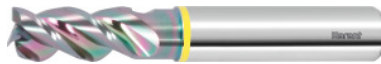


Garant**Solid carbide milling cutter MTC, DLC, Ø DC: 2,5mm****Order data**

Order number	202272 2,5
GTIN	4045197861115
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 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 HA to h6

No. of teeth Z: 3

Flute length L_c : 6.5 mm

Overhang length L_1 incl. recess: 12.5 mm

Recess Ø D_1 : 2.4 mm

Overall length L: 57 mm

Shank Ø D_s : 6 mm

Technical description

Overhang length L_1 incl. recess	12.5 mm
Feed f_z for side milling in short-chipping aluminium	0.009 mm

Feed f_z for slot milling in short-chipping aluminium	0.006 mm
Flute length L_c	6.5 mm
Direction of infeed	horizontal, oblique and vertical
Tolerance nominal $\varnothing$	h6
Overall length L	57 mm
Recess $\varnothing D_1$	2.4 mm
Shank form	HA
Shank	DIN 6535 HA to h6
Cutting edge $\varnothing D_c$	2.5 mm
No. of teeth Z	3
Shank $\varnothing D_s$	6 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