

**Garant**
**Solid carbide milling cutter MTC, uncoated, Ø DC: 8,5 mm**

**Order data**

Order number	202244 8,5
GTIN	4045197654755
Item class	11X

**Description**
**Version:**

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

**Without** 45° corner chamfer.

**Without** 45° corner chamfer.

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.

**Note:**

**NEW GENERATION AVAILABLE! Recommended successor product is No. 202002.**

Tolerance nominal Ø: h6

No. of teeth Z: 3

Helix angle: 45 degrees

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  $L_c$ : 22 mm

Overhang length  $L_1$  incl. recess: 30 mm

Recess Ø  $D_1$ : 7.9 mm

Overall length L: 72 mm

Shank Ø  $D_s$ : 10 mm

**Technical description**

Feed $f_z$ for side milling in short-chipping aluminium	0.04 mm
---	---------

Cutting edge Ø D <sub>c</sub>	8.5 mm
Feed f <sub>z</sub> for slot milling in short-chipping aluminium	0.03 mm
No. of teeth Z	3
Overhang length L <sub>1</sub> incl. recess	30 mm
Recess Ø D <sub>1</sub>	7.9 mm
Shank form	HA
Shank Ø D <sub>s</sub>	10 mm
Overall length L	72 mm
Flute length L <sub>c</sub>	22 mm
Direction of infeed	horizontal, oblique and vertical
Shank	DIN 6535 HA to h6
Tolerance nominal Ø	h6
Balance quality with shank	G 2.5 with HA
Helix angle	45 degrees
Corner chamfer angle	90 degrees
Coating	uncoated
Tool material	Solid carbide
Standard	DIN 6527
Type	W
Helix angle characteristic	unequal spacing
Cutting width a <sub>e</sub> for milling operation	0.5×D for side milling
Cutting width a <sub>e</sub> for milling operation	Full slot cutting depth 1×D
Through-coolant	no
Machining strategy	MTC
Colour ring	yellow
Type of product	End mill

## Services

Shank grinding Type HB	129100 HB
------------------------	-----------

