

## Garant

**Solid carbide milling cutter with internal coolant supply MTC, uncoated, Ø DC: 8 mm**



### Order data

|              |               |
|--------------|---------------|
| Order number | 202249 8      |
| GTIN         | 4045197657329 |
| Item class   | 11X           |

### Description

#### Version:

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

Lengths similar to **DIN 6527 long**.

#### 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 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  $L_c$ : 21 mm

Overhang length  $L_1$  incl. recess: 25 mm

Recess Ø  $D_1$ : 7.4 mm

Overall length L: 63 mm

Shank Ø  $D_s$ : 8 mm

### Technical description

|   |         |
|---|---------|
| Recess Ø $D_1$  | 7.4 mm  |
| Corner chamfer width at 45°                             | 0.2 mm  |
| Feed $f_z$ for slot milling in short-chipping aluminium | 0.03 mm |

|   |                                  |
|---|----------------------------------|
| Overhang length $L_1$ incl. recess                      | 25 mm                            |
| Cutting edge $\varnothing D_c$                          | 8 mm                             |
| No. of teeth Z  | 3                                |
| Shank form  | HA                               |
| Feed $f_z$ for side milling in short-chipping aluminium | 0.04 mm                          |
| Shank $\varnothing D_s$                                 | 8 mm                             |
| Overall length L  | 63 mm                            |
| Flute length $L_c$                                      | 21 mm                            |
| Direction of infeed                                     | horizontal, oblique and vertical |
| Shank   | DIN 6535 HA to h6                |
| Tolerance nominal $\varnothing$                         | h6                               |
| Balance quality with shank                              | G 2.5 with HA                    |
| Helix angle   | 45 degrees                       |
| Corner chamfer angle                                    | 45 degrees                       |
| Coating   | uncoated                         |
| 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   | yes                              |
| Machining strategy                                      | MTC                              |
| Colour ring   | yellow                           |
| Type of product   | End mill                         |

## Services

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

