

## Solid carbide milling cutter MTC, DLC, Ø DC: 6M mm



### **Order data**

Order number	202272 6M
GTIN	4045197763983
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  $\varnothing$  **D**<sub>C</sub> = **e8.** 

Size 2.5–20M – tolerance: Size nominal  $\varnothing$  **D**<sub>C</sub> = **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 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<sub>c</sub>: 18 mm

Overhang length L<sub>1</sub> incl. recess: 24 mm

Recess  $\varnothing$  D<sub>1</sub>: 5.7 mm Overall length L: 62 mm Shank  $\varnothing$  D<sub>5</sub>: 6 mm

## **Technical description**

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

Direction of infeed Flute length L <sub>c</sub> 18 mm  Balance quality with shank  Shank Ø D <sub>c</sub> 6 mm  Shank form  HA  Overhang length L <sub>1</sub> incl. recess  24 mm  Shank  DIN 6535 HA to h6  Tolerance nominal Ø  Feed f <sub>c</sub> for side milling in short-chipping aluminium  Recess Ø D <sub>1</sub> No. of teeth Z  3  Overall length L  Helix angle  Corner chamfer angle  Coating  DLC  Tool material  Standard  DIN 6527  Type  W  Helix angle characteristic  unequal spacing  Cutting width a <sub>c</sub> for milling operation  Full slot cutting depth 1 × D  Through-coolant  no  Machining strategy  MTC  Colour ring  Wellow	Cutting edge Ø D <sub>c</sub>	6 mm
Balance quality with shank  Shank Ø D₂  6 mm  Shank form  HA  Overhang length L₁ incl. recess  24 mm  Shank  DIN 6535 HA to h6  Tolerance nominal Ø  Feed f₂ for side milling in short-chipping aluminium  Recess Ø D₁  No. of teeth Z  3  Overall length L  Helix angle  Corner chamfer angle  Coating  DLC  Tool material  Solid carbide  Standard  DIN 6527  Type  W  Helix angle characteristic  unequal spacing  Cutting width a₂ for milling operation  Cutting width a₂ for milling operation  Machining strategy  MTC	Direction of infeed	horizontal, oblique and vertical
Shank Ø D₅       6 mm         Shank form       HA         Overhang length L₁ incl. recess       24 mm         Shank       DIN 6535 HA to h6         Tolerance nominal Ø       h6         Feed f₂ for side milling in short-chipping aluminium       0.03 mm         Recess Ø D₁       5.7 mm         No. of teeth Z       3         Overall length L       62 mm         Helix angle       45 degrees         Corner chamfer angle       90 degrees         Coating       DLC         Tool material       Solid carbide         Standard       DIN 6527         Type       W         Helix angle characteristic       unequal spacing         Cutting width a₂ for milling operation       0.5×D for side milling         Cutting width a₂ for milling operation       Full slot cutting depth 1×D         Through-coolant       no         Machining strategy       MTC	Flute length L <sub>c</sub>	18 mm
Shank form       HA         Overhang length L₁ incl. recess       24 mm         Shank       DIN 6535 HA to h6         Tolerance nominal Ø       h6         Feed f₂ for side milling in short-chipping aluminium       0.03 mm         Recess Ø D₁       5.7 mm         No. of teeth Z       3         Overall length L       62 mm         Helix angle       45 degrees         Corner chamfer angle       90 degrees         Coating       DLC         Tool material       Solid carbide         Standard       DIN 6527         Type       W         Helix angle characteristic       unequal spacing         Cutting width a₂ for milling operation       0.5×D for side milling         Cutting width a₂ for milling operation       Full slot cutting depth 1×D         Through-coolant       no         Machining strategy       MTC	Balance quality with shank	G 2.5 with HA
Overhang length L₁ incl. recess       24 mm         Shank       DIN 6535 HA to h6         Tolerance nominal Ø       h6         Feed f₂ for side milling in short-chipping aluminium       0.03 mm         Recess Ø D₁       5.7 mm         No. of teeth Z       3         Overall length L       62 mm         Helix angle       45 degrees         Corner chamfer angle       90 degrees         Coating       DLC         Tool material       Solid carbide         Standard       DIN 6527         Type       W         Helix angle characteristic       unequal spacing         Cutting width a₂ for milling operation       0.5×D for side milling         Cutting width a₂ for milling operation       Full slot cutting depth 1×D         Through-coolant       no         Machining strategy       MTC	Shank Ø D <sub>s</sub>	6 mm
Shank  DIN 6535 HA to h6  Tolerance nominal Ø  Feed f₂ for side milling in short-chipping aluminium  Recess Ø D₁  No. of teeth Z  Overall length L  Helix angle  Corner chamfer angle  Coating  DLC  Tool material  Solid carbide  Standard  DIN 6527  Type  W  Helix angle characteristic  Cutting width ae for milling operation  Cutting width ae for milling operation  Machining strategy  MTC	Shank form	НА
Tolerance nominal $\varnothing$ h6  Feed $f_z$ for side milling in short-chipping aluminium 0.03 mm  Recess $\varnothing$ D <sub>1</sub> 5.7 mm  No. of teeth Z 3  Overall length L 62 mm  Helix angle 45 degrees  Corner chamfer angle 90 degrees  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	Overhang length L₁ incl. recess	24 mm
Feed $f_z$ for side milling in short-chipping aluminium0.03 mmRecess $\varnothing$ D15.7 mmNo. of teeth Z3Overall length L62 mmHelix angle45 degreesCorner chamfer angle90 degreesCoatingDLCTool materialSolid carbideStandardDIN 6527TypeWHelix angle characteristicunequal spacingCutting width $a_c$ for milling operation0.5×D for side millingCutting width $a_c$ for milling operationFull slot cutting depth 1×DThrough-coolantnoMachining strategyMTC	Shank	DIN 6535 HA to h6
Recess $\varnothing$ D15.7 mmNo. of teeth Z3Overall length L62 mmHelix angle45 degreesCorner chamfer angle90 degreesCoatingDLCTool materialSolid carbideStandardDIN 6527TypeWHelix angle characteristicunequal spacingCutting width $a_e$ for milling operation $0.5 \times D$ for side millingCutting width $a_e$ for milling operationFull slot cutting depth $1 \times D$ Through-coolantnoMachining strategyMTC	Tolerance nominal Ø	h6
No. of teeth Z  Overall length L  Helix angle  Corner chamfer angle  Coating  DLC  Tool material  Solid carbide  Standard  DIN 6527  Type  W  Helix angle characteristic  unequal spacing  Cutting width ae for milling operation  Cutting width ae for milling operation  Through-coolant  Machining strategy  A 5 degrees  90 degrees  Solid carbide  Solid carbide  DIN 6527  Type  W  Helix angle characteristic  unequal spacing  Full slot cutting depth 1×D	Feed $f_z$ for side milling in short-chipping aluminium	0.03 mm
Overall length L  Helix angle  Corner chamfer angle  Coating  DLC  Tool material  Solid carbide  Standard  DIN 6527  Type  W  Helix angle characteristic  unequal spacing  Cutting width a <sub>e</sub> for milling operation  Cutting width a <sub>e</sub> for milling operation  Through-coolant  Machining strategy  A 5 degrees  90 degrees  DLC  Solid carbide  Standard  DIN 6527  Type  W  Helix angle characteristic  unequal spacing  Cutting width a <sub>e</sub> for milling operation  Full slot cutting depth 1×D  MTC	Recess Ø D <sub>1</sub>	5.7 mm
Helix angle  Corner chamfer angle  Coating  DLC  Tool material  Solid carbide  Standard  DIN 6527  Type  W  Helix angle characteristic  unequal spacing  Cutting width a <sub>e</sub> for milling operation  Cutting width a <sub>e</sub> for milling operation  Full slot cutting depth 1×D  Through-coolant  Machining strategy  MTC	No. of teeth Z	3
Corner chamfer angle  Coating  DLC  Tool material  Solid carbide  Standard  DIN 6527  Type  W  Helix angle characteristic  unequal spacing  Cutting width a <sub>e</sub> for milling operation  Cutting width a <sub>e</sub> for milling operation  Through-coolant  Machining strategy  MTC	Overall length L	62 mm
Coating DLC  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	Helix angle	45 degrees
Tool material  Solid carbide  Standard  DIN 6527  Type  W  Helix angle characteristic  unequal spacing  Cutting width a <sub>e</sub> for milling operation  Cutting width a <sub>e</sub> for milling operation  Full slot cutting depth 1×D  Through-coolant  no  Machining strategy  MTC	Corner chamfer angle	90 degrees
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	Coating	DLC
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	Tool material	Solid carbide
Helix angle characteristic unequal spacing  Cutting width $a_e$ for milling operation $0.5 \times D$ for side milling  Cutting width $a_e$ for milling operation Full slot cutting depth $1 \times D$ Through-coolant no  Machining strategy MTC	Standard	DIN 6527
Cutting width $a_e$ for milling operation $0.5 \times D$ for side millingCutting width $a_e$ for milling operationFull slot cutting depth $1 \times D$ Through-coolantnoMachining strategyMTC	Туре	W
Cutting width $a_e$ for milling operationFull slot cutting depth $1 \times D$ Through-coolantnoMachining strategyMTC	Helix angle characteristic	unequal spacing
Through-coolant no Machining strategy MTC	Cutting width a <sub>e</sub> for milling operation	0.5×D for side milling
Machining strategy MTC	Cutting width a <sub>e</sub> for milling operation	Full slot cutting depth 1×D
	Through-coolant	no
Colour ring	Machining strategy	MTC
yellow	Colour ring	yellow
Type of product End mill	Type of product	End mill

# Services

Shank grinding Type HB 129100 HB

