

# Solid carbide milling cutter MTC, AlCrN, Ø f8 DC: 2,5 mm



## **Order data**

Order number	202396 2,5
GTIN	4045197857453
Item class	11X

# **Description**

#### **Version:**

Special flute profile. Strengthened core.

MTC rough milling up to 1.5×D in solid material.

## **Eccentric relief ground.**

Lengths similar to **DIN 6527 long**.

Improved coating for a further reduction in cutting force combined with increased tool life.

### **Application:**

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

Tolerance nominal Ø: f8

No. of teeth Z: 3

Helix angle: 45 degrees

Direction of infeed: horizontal, oblique and vertical

Shank: DIN 6535 HB to h6

Balance quality with shank: G 2.5 with HB

No. of teeth Z: 3

Flute length L<sub>c</sub>: 6.5 mm

Overhang length L<sub>1</sub> incl. recess: 12.5 mm

Recess  $\emptyset$  D<sub>1</sub>: 2.4 mm Overall length L: 57 mm Shank  $\emptyset$  D<sub>4</sub>: 6 mm

## **Technical description**

Overhang length L <sub>1</sub> incl. recess	12.5 mm
Direction of infeed	horizontal, oblique and vertical
Tolerance nominal Ø	f8

Balance quality with shank       G 2.5 with HB         Cutting edge $\varnothing$ $D_c$ 2.5 mm         Feed $f_c$ for side milling in steel < 900 N/mm²       0.024 mm         No. of teeth Z       3         Recess $\varnothing$ $D_1$ 2.4 mm         Overall length L       57 mm         Shank $\varnothing$ $D_c$ 6 mm         Shank $O_c$ 0.05 mm         Helix angle       45 degrees         Corner chamfer width at 45°       0.05 mm         Helix angle       45 degrees         Coating       AlCrN         Tool material       Solid carbide         Standard       DIN 6527         Type       N         Helix angle characteristic       unequal spacing         Spacing of the cutters       unequal spacing         Cutting width $a_c$ for milling operation       Full slot cutting depth 1×D         Cutting width $a_c$ for milling operation       0.5×D for side milling         Through-coolant       no         Machining strategy       MTC         Colour ring       green	Flute length L <sub>c</sub>	6.5 mm
Cutting edge $\varnothing$ D <sub>C</sub> Feed f <sub>z</sub> for side milling in steel < 900 N/mm²  No. of teeth Z  Recess $\varnothing$ D <sub>1</sub> Overall length L  Shank $\varnothing$ D <sub>2</sub> Shank  DIN 6535 HB to h6  Corner chamfer width at 45°  Helix angle  Coating  Coating  AlCrN  Tool material  Standard  DIN 6527  Type  N  Helix angle characteristic  Spacing of the cutters  Cutting width a <sub>z</sub> for milling operation  Cutting width a <sub>z</sub> for milling operation  Machining strategy  Colour ring  D.024 mm  0.024 mm  0.05 mm  Alcrn  DIN 6527 Type  N  Helix angle characteristic  Unequal spacing  Full slot cutting depth 1×D  Cutting width a <sub>z</sub> for milling operation  0.5×D for side milling  Through-coolant  no  Machining strategy  MTC  Colour ring	Feed f <sub>z</sub> for slot milling in steel < 900 N/mm <sup>2</sup>	0.02 mm
Feed $f_z$ for side milling in steel < 900 N/mm²  No. of teeth $Z$ 3  Recess $\varnothing$ D <sub>1</sub> 2.4 mm  Overall length L  57 mm  Shank $\varnothing$ D <sub>5</sub> 6 mm  Shank  DIN 6535 HB to h6  Corner chamfer width at 45°  Helix angle  Corner chamfer angle  45 degrees  Corner chamfer angle  Coating  AlCrN  Tool material  Solid carbide  Standard  DIN 6527  Type  N  Helix angle characteristic  unequal spacing  Spacing of the cutters  unequal spacing  Cutting width $a_s$ for milling operation  Cutting width $a_s$ for milling operation  Through-coolant  Machining strategy  MTC  Colour ring  green	Balance quality with shank	G 2.5 with HB
No. of teeth Z  Recess Ø D₁  Overall length L  Shank Ø D₂  Shank  DIN 6535 HB to h6  Corner chamfer width at 45°  Helix angle  Corner chamfer angle  Coating  AlCrN  Tool material  Solid carbide  Standard  DIN 6527  Type  N  Helix angle characteristic  Spacing of the cutters  Cutting width a₂ for milling operation  Cutting width a₂ for milling operation  Through-coolant  Machining strategy  Colour ring  Sol MTC  Al mm  2.4 mm  3  Al mm  50 mm  Al crn  Al Crn	Cutting edge Ø D <sub>C</sub>	2.5 mm
Recess Ø D₁  Overall length L  57 mm  Shank Ø D₂  Shank  DIN 6535 HB to h6  Corner chamfer width at 45°  Helix angle  Corner chamfer angle  Coating  AlCrN  Tool material  Solid carbide  Standard  DIN 6527  Type  N  Helix angle characteristic  Spacing of the cutters  Cutting width a₂ for milling operation  Cutting width a₂ for milling operation  Machining strategy  Colour ring  Page of mm  2.4 mm  2.4 mm  2.4 mm  2.4 mm  2.4 mm  2.4 mm  2.5 mm  8 mm  8 mm  8 bin 6535 HB to h6  0.05 mm  AlCrN  AlCrN  Solid carbide  DIN 6527  Type  N  Helix angle characteristic  unequal spacing  Full slot cutting depth 1×D  Cutting width a₂ for milling operation  0.5×D for side milling  Through-coolant  no  Machining strategy  MTC  Colour ring  green	Feed f <sub>z</sub> for side milling in steel < 900 N/mm <sup>2</sup>	0.024 mm
Overall length L Shank Ø D, Shank DIN 6535 HB to h6 Corner chamfer width at 45° 0.05 mm Helix angle 45 degrees Corner chamfer angle Coating AlCrN Tool material Solid carbide Standard DIN 6527 Type N Helix angle characteristic unequal spacing Spacing of the cutters unequal spacing Cutting width ae for milling operation Full slot cutting depth 1×D Cutting width ae for milling operation Machining strategy MTC Colour ring Spacing of mm MTC MTC Spacing MTC MTC Colour ring Spacing DIN 6537 Type N Unequal spacing Full slot cutting depth 1×D O.5×D for side milling MTC Glour ring Green	No. of teeth Z	3
Shank Ø D₃ Shank DIN 6535 HB to h6 Corner chamfer width at 45° 0.05 mm Helix angle 45 degrees Corner chamfer angle 45 degrees Coating AlCrN Tool material Solid carbide Standard DIN 6527 Type N Helix angle characteristic unequal spacing Spacing of the cutters unequal spacing Cutting width ae for milling operation Full slot cutting depth 1×D Cutting width ae for milling operation Machining strategy MTC Colour ring Space MACC MACC MACC MACC MACC MACC MACC MACC	Recess Ø D <sub>1</sub>	2.4 mm
Shank  Corner chamfer width at 45°  Helix angle  Corner chamfer angle  Corner chamfer angle  Coating  AlCrN  Tool material  Solid carbide  Standard  DIN 6527  Type  N  Helix angle characteristic  Spacing of the cutters  Cutting width a <sub>e</sub> for milling operation  Cutting width a <sub>e</sub> for milling operation  Machining strategy  MTC  Colour ring	Overall length L	57 mm
Corner chamfer width at 45°  Helix angle  Corner chamfer angle  Coating  AlCrN  Tool material  Solid carbide  Standard  DIN 6527  Type  N  Helix angle characteristic  unequal spacing  Spacing of the cutters  unequal spacing  Cutting width ae for milling operation  Cutting width ae for milling operation  Through-coolant  Machining strategy  MTC  Colour ring  O.55 mm  0.05 mm  0.05 mm  0.05 mm  45 degrees  AlCrN  Solid carbide  Solid carbide  Unequal spacing  Full slot cutting depth 1×D  0.5×D for side milling  MTC  Glour ring  Green	Shank Ø D <sub>s</sub>	6 mm
Helix angle  Corner chamfer angle  Coating  AlCrN  Tool material  Solid carbide  Standard  DIN 6527  Type  N  Helix angle characteristic  unequal spacing  Spacing of the cutters  unequal spacing  Cutting width ae for milling operation  Cutting width ae for milling operation  Cutting width ae for milling operation  Through-coolant  Machining strategy  MTC  Colour ring  AlCrN  Solid carbide  Solid carbide  Sull 6527  N  Full slot cutting depth 1×D  O.5×D for side milling  MTC  Golour ring  green	Shank	DIN 6535 HB to h6
Corner chamfer angle  Coating  AlCrN  Tool material  Solid carbide  Standard  DIN 6527  Type  N  Helix angle characteristic  Spacing of the cutters  Cutting width a <sub>e</sub> for milling operation  Cutting width a <sub>e</sub> for milling operation  Cutting width a <sub>e</sub> for milling operation  Through-coolant  Machining strategy  MTC  Colour ring  AlCrN  Solid carbide  DIN 6527  N  unequal spacing  unequal spacing  Full slot cutting depth 1×D  0.5×D for side milling  MTC	Corner chamfer width at 45°	0.05 mm
Coating  Tool material  Solid carbide  Standard  DIN 6527  Type  N  Helix angle characteristic  Spacing of the cutters  Cutting width a <sub>e</sub> for milling operation  Cutting width a <sub>e</sub> for milling operation  Cutting width a <sub>e</sub> for milling operation  Through-coolant  Machining strategy  MTC  Colour ring  AlCrN  Solid carbide  N  N  N  N  Mequal spacing  Full slot cutting depth 1×D  O.5×D for side milling  MTC	Helix angle	45 degrees
Tool material  Solid carbide  Standard  DIN 6527  Type  N  Helix angle characteristic  unequal spacing  Spacing of the cutters  unequal spacing  Cutting width a <sub>e</sub> for milling operation  Full slot cutting depth 1×D  Cutting width a <sub>e</sub> for milling operation  O.5×D for side milling  Through-coolant  no  Machining strategy  MTC  Colour ring  green	Corner chamfer angle	45 degrees
StandardDIN 6527TypeNHelix angle characteristicunequal spacingSpacing of the cuttersunequal spacingCutting width $a_e$ for milling operationFull slot cutting depth $1 \times D$ Cutting width $a_e$ for milling operation $0.5 \times D$ for side millingThrough-coolantnoMachining strategyMTCColour ringgreen	Coating	AlCrN
Type N Helix angle characteristic unequal spacing Spacing of the cutters unequal spacing Cutting width ae for milling operation Full slot cutting depth 1×D Cutting width ae for milling operation 0.5×D for side milling Through-coolant no Machining strategy MTC Colour ring green	Tool material	Solid carbide
Helix angle characteristic  Spacing of the cutters  Cutting width a <sub>e</sub> for milling operation  Through-coolant  Machining strategy  MTC  Colour ring  unequal spacing  Full slot cutting depth 1×D  0.5×D for side milling  no  MTC	Standard	DIN 6527
Spacing of the cuttersunequal spacingCutting width $a_e$ for milling operationFull slot cutting depth $1 \times D$ Cutting width $a_e$ for milling operation $0.5 \times D$ for side millingThrough-coolantnoMachining strategyMTCColour ringgreen	Туре	N
Cutting width $a_e$ for milling operationFull slot cutting depth $1 \times D$ Cutting width $a_e$ for milling operation $0.5 \times D$ for side millingThrough-coolantnoMachining strategyMTCColour ringgreen	Helix angle characteristic	unequal spacing
Cutting width $a_e$ for milling operation $0.5 \times D$ for side millingThrough-coolantnoMachining strategyMTCColour ringgreen	Spacing of the cutters	unequal spacing
Through-coolant no Machining strategy MTC Colour ring green	Cutting width a <sub>e</sub> for milling operation	Full slot cutting depth 1×D
Machining strategy MTC Colour ring green	Cutting width a <sub>e</sub> for milling operation	0.5×D for side milling
Colour ring green	Through-coolant	no
	Machining strategy	MTC
Type of product End mill	Colour ring	green
	Type of product	End mill