

Solid carbide milling cutter MTC, AlCrN, Ø f8 DC: 4 mm



Order data

Order number	202399 4
GTIN	4045197854575
Item class	11X

Description

Version:

Special flute profile. Strengthened core.

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

Eccentric relief ground.

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_c: 16 mm

Overhang length L₁ incl. recess: 24 mm

Recess \varnothing D₁: 3.9 mm Overall length L: 62 mm Shank \varnothing D₅: 6 mm

Technical description

Overall length L	62 mm
Direction of infeed	horizontal, oblique and vertical
Recess Ø D ₁	3.9 mm
Shank	DIN 6535 HB to h6

Feed f_ϵ for side milling in steel < 900 N/mm² 0.024 mm Tolerance nominal Ø f8 Overhang length L_1 incl. recess 24 mm Corner chamfer width at 45° 0.1 mm Flute length L_ϵ 16 mm No. of teeth Z 3 Balance quality with shank G 2.5 with HB Cutting edge Ø D_c 4 mm Feed f_ϵ for slot milling in steel < 900 N/mm² 0.02 mm Helix angle 45 degrees Corner chamfer angle 45 degrees Coating AlCrN Tool material Solid carbide Standard Manufacturer's standard Type N Helix angle characteristic unequal spacing Spacing of the cutters unequal spacing Cutting width a_ϵ for milling operation 0.3×D for side milling Cutting width a_ϵ for milling operation Full slot cutting depth 1×D Through-coolant no Machining strategy MTC Colour ring green Type of product End mill	Shank Ø D _s	6 mm
Overhang length L₁ incl. recess 24 mm Corner chamfer width at 45° 0.1 mm Flute length L₂ 16 mm No. of teeth Z 3 Balance quality with shank G 2.5 with HB Cutting edge Ø D₂ 4 mm Feed f₂ for slot milling in steel < 900 N/mm²	Feed f _z for side milling in steel < 900 N/mm ²	0.024 mm
Corner chamfer width at 45° Corner chamfer width at 45° Flute length L₂ Balance quality with shank Cutting edge Ø D₂ Feed f₂ for slot milling in steel < 900 N/mm² Helix angle Corner chamfer angle Corner chamfer angle Coating Tool material Solid carbide Standard Manufacturer's standard Type N Helix angle characteristic unequal spacing Spacing of the cutters unequal spacing Cutting width a₂ for milling operation Cutting width a₂ for milling operation Through-coolant Machining strategy Colour ring O.1 mm 16 mm N A mm G 2.5 with HB A mm Feed f₂ for slot milling AlCrN All CrN N Helix angle N Helix angle characteristic unequal spacing Full slot cutting depth 1×D Through-coolant no Machining strategy MTC Colour ring	Tolerance nominal Ø	f8
Flute length L_c 16 mm No. of teeth Z 3 Balance quality with shank G 2.5 with HB Cutting edge \varnothing D_c 4 mm Feed f_z for slot milling in steel < 900 N/mm² 0.02 mm Helix angle 45 degrees Corner chamfer angle 45 degrees Coating AlCrN Tool material Solid carbide Standard Manufacturer's standard Type N Helix angle characteristic unequal spacing Spacing of the cutters unequal spacing Cutting width a_e for milling operation 0.3×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 green	Overhang length L₁ incl. recess	24 mm
No. of teeth Z Balance quality with shank Cutting edge Ø D _c A mm Feed f _z for slot milling in steel < 900 N/mm² Helix angle Corner chamfer angle Coating AlCrN Tool material Solid carbide Standard Manufacturer's standard Type N Helix angle characteristic unequal spacing Spacing of the cutters unequal spacing Cutting width a _e for milling operation Cutting width a _e for milling operation Through-coolant Machining strategy MTC Colour ring G 4 mm G 2.5 with HB G 2.5 with Ha G 2.5 with HB G 2.5 with Ha G	Corner chamfer width at 45°	0.1 mm
Balance quality with shank G 2.5 with HB Cutting edge Ø Dc 4 mm Feed f₂ for slot milling in steel < 900 N/mm²	Flute length L _c	16 mm
Cutting edge \emptyset D _C Feed f _z for slot milling in steel < 900 N/mm ² 0.02 mm Helix angle 45 degrees Corner chamfer angle Coating AlCrN Tool material Solid carbide Standard Manufacturer's standard Type N Helix angle characteristic unequal spacing Spacing of the cutters unequal spacing Cutting width a _e for milling operation Cutting width a _e for milling operation Full slot cutting depth 1×D Through-coolant no Machining strategy MTC Colour ring	No. of teeth Z	3
Feed f_z for slot milling in steel < 900 N/mm² 0.02 mm Helix angle 45 degrees Corner chamfer angle 45 degrees CoatingAlCrNTool materialSolid carbideStandardManufacturer's standardTypeNHelix angle characteristicunequal spacingSpacing of the cuttersunequal spacingCutting width a_e for milling operation $0.3 \times D$ for side millingCutting width a_e for milling operationFull slot cutting depth $1 \times D$ Through-coolantnoMachining strategyMTCColour ringgreen	Balance quality with shank	G 2.5 with HB
Helix angle Corner chamfer angle Coating AlCrN Tool material Solid carbide Standard Manufacturer's standard 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 no Machining strategy MTC Colour ring	Cutting edge Ø D _C	4 mm
Corner chamfer angle Coating AlCrN Tool material Solid carbide Standard Manufacturer's standard 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 Full slot cutting depth 1×D Through-coolant no Machining strategy MTC Colour ring Gaterian AlCrN AlCrN AlCrN AlCrN AllCrN Solid carbide Manufacturer's standard unequal spacing Unequal spacing Unequal spacing Full slot cutting depth 1×D Through-coolant no Machining strategy MTC Colour ring Green	Feed f _z for slot milling in steel < 900 N/mm ²	0.02 mm
Coating AlCrN Tool material Solid carbide Standard Manufacturer's standard Type N Helix angle characteristic unequal spacing Spacing of the cutters unequal spacing Cutting width a _e for milling operation Cutting width a _e for milling operation Full slot cutting depth 1×D Through-coolant no Machining strategy MTC Colour ring Golden AlCrN Solid carbide Nanufacturer's standard N N Full spacing Full slot cutting MTC Golour ring Green	Helix angle	45 degrees
Tool material Solid carbide Standard Manufacturer's standard Type N Helix angle characteristic Spacing of the cutters Cutting width a _e for milling operation Cutting width a _e for milling operation Through-coolant Machining strategy Colour ring Solid carbide Manufacturer's standard N N N Pull spacing Spacing O.3×D for side milling Full slot cutting depth 1×D MTC Golour ring Green	Corner chamfer angle	45 degrees
StandardManufacturer's standardTypeNHelix angle characteristicunequal spacingSpacing of the cuttersunequal spacingCutting width ae for milling operation0.3×D for side millingCutting width ae for milling operationFull slot cutting depth 1×DThrough-coolantnoMachining strategyMTCColour ringgreen	Coating	AlCrN
Type N Helix angle characteristic unequal spacing Spacing of the cutters unequal spacing Cutting width a _e for milling operation 0.3×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 green	Tool material	Solid carbide
Helix angle characteristic unequal spacing Spacing of the cutters unequal spacing Cutting width a _e for milling operation 0.3×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 green	Standard	Manufacturer's standard
Spacing of the cuttersunequal spacingCutting width a_e for milling operation $0.3 \times D$ for side millingCutting width a_e for milling operationFull slot cutting depth $1 \times D$ Through-coolantnoMachining strategyMTCColour ringgreen	Туре	N
Cutting width a _e for milling operation Cutting width a _e for milling operation Full slot cutting depth 1×D Through-coolant Machining strategy MTC Colour ring green	Helix angle characteristic	unequal spacing
Cutting width a _e for milling operation Through-coolant Machining strategy MTC Colour ring Full slot cutting depth 1×D MTC green	Spacing of the cutters	unequal spacing
Through-coolant no Machining strategy MTC Colour ring green	Cutting width a _e for milling operation	0.3×D for side milling
Machining strategy MTC Colour ring green	Cutting width a _e for milling operation	Full slot cutting depth 1×D
Colour ring green	Through-coolant	no
	Machining strategy	MTC
Type of product End mill	Colour ring	green
	Type of product	End mill