

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

**Order data**

Order number	202391 2,5
GTIN	4062406270780
Item class	11X

**Description**
**Version:**

**Special flute profile. Strengthened core.**

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

**Eccentric relief ground.**

Particularly sturdy due to short overall length. Overall length similar to **DIN 6527 short**.

**Application:**

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

**Technical description**

Tolerance nominal Ø	f8
Recess Ø D <sub>1</sub>	2.3 mm
Shank	DIN 6535 HA to h6
No. of teeth Z	3
Feed f <sub>z</sub> for side milling in steel < 900 N/mm <sup>2</sup>	0.024 mm
Overall length L	50 mm
Cutting edge Ø D <sub>c</sub>	2.5 mm
Direction of infeed	horizontal, oblique and vertical
Feed f <sub>z</sub> for slot milling in steel < 900 N/mm <sup>2</sup>	0.02 mm
Flute length L <sub>c</sub>	4 mm
Balance quality with shank	G 2.5 with HA

Shank $\varnothing D_s$	6 mm
Overhang length $L_1$ incl. recess	10 mm
Corner chamfer width at $45^\circ$	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 $a_e$ for milling operation	Full slot cutting depth $1 \times D$
Cutting width $a_e$ for milling operation	Full slot cutting depth $1 \times D$
Through-coolant	no
Machining strategy	MTC
Colour ring	green
Type of product	End / face mill

## User data

	Suitability	$V_c$	ISO code
Steel < 500 N/mm <sup>2</sup>	suitable	250 m/min	P
Steel < 750 N/mm <sup>2</sup>	suitable	220 m/min	P
Steel < 900 N/mm <sup>2</sup>	Suitable	200 m/min	P
Steel < 1100 N/mm <sup>2</sup>	Suitable	190 m/min	P
Steel < 1400 N/mm <sup>2</sup>	suitable	170 m/min	P
Steel < 55 HRC	suitable	90 m/min	H
Steel < 60 HRC	suitable	60 m/min	H
INOX < 900 N/mm <sup>2</sup>	suitable	130 m/min	M
INOX > 900 N/mm <sup>2</sup>	Suitable	100 m/min	M

Ti > 850 N/mm <sup>2</sup>	suitable only under restricted conditions	50 m/min	S
GG(G)	suitable	160 m/min	K
Uni	suitable		
wet maximum	Suitable		
wet minimum	suitable only under restricted conditions		
dry	Suitable		
Air	Suitable		