

MCA145

Weldon

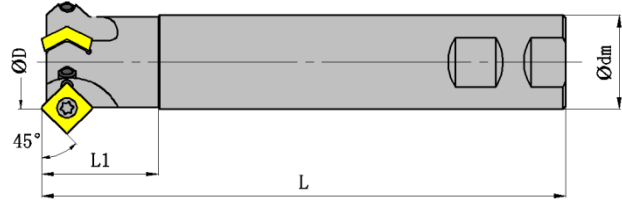
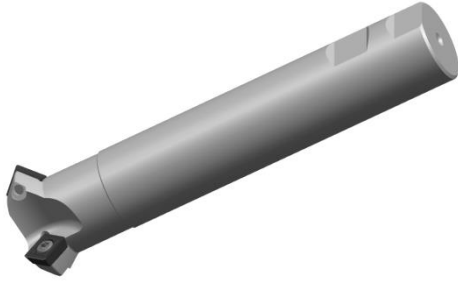




Fig2

Ordering Code	Diameters	Teeth	(mm)					ap	Gauge Insert	Coolant	Shape	Stock
			Dimensions									
			ΦD	Φdm	CH	L	L ₁					
MCA145025R02W25SP09	25	2	25	25	45	120	40	5	SPMT09T308-CM	×	Fig2	●
MCA145032R03W32SP12	32	3	32	32	45	180	40	7	SPMT120408-CM	×	Fig2	●

● Stock ○ Available upon Order

Spare Parts

Parts	Insert Screw	Insert Spanner
Insert Shape		
SPMT09T308-CM	SI60M4X9	TT15P
SPMT120408-CM	SI60M5X10	TT15P

Recommended Cutting Data

	Workpiece Material	Material Hardness	Grade	Cutting Speed	(mm/tooth)	
				Vc (m/min)	(M) Medium Cutting	(H) Heavy Cutting
P	Mild Steel	≤HB200	GA4225 GA4230	180 (150-200)	0.25 (0.1-0.4)	0.4 (0.1-0.5)
	Carbon Steel Alloy Steel	≤HRC35	GA4225 GA4230	150 (120-180)	0.3 (0.1-0.4)	0.4 (0.1-0.5)
	Carbon Steel Alloy Steel	HRC35-45	GA4225 GA4230	120 (80-150)	0.3 (0.1-0.4)	0.4 (0.1-0.5)
M	Stainless Steel (Ferrite, Martensite)	≤HRC35	GM2140	120 (80-160)	0.3 (0.1-0.4)	0.4 (0.1-0.5)
K	Cast Iron Nodular Cast Iron	≤HB350	GK4125	130 (90-160)	0.3 (0.1-0.4)	0.4 (0.1-0.5)
S	Heat-resistant Alloy and Titanium Alloy	≤HRC35	GA4230	40 (30-60)	0.2 (0.1-0.3)	0.3 (0.15-0.35)
H	Hardened Steel	HRC45-55	GA4230	80 (60-100)	0.1 (0.1-0.2)	0.2 (0.15-0.25)