

Garant
Solid carbide corner rounding cutter HPC, TiAlN, Radius r: 1,5mm

Order data

Order number	208021 1,5
GTIN	4062406103484
Item class	11X

Description
Version:
Straight fluted, without profile distortion.

Tolerance: $r = \pm 0.01$ mm.

Application:

For rounding and deburring **edges**.

Technical description

No. of teeth Z	4
Shank $\varnothing D_s$	6 mm
Overall length L	50 mm
Feed f_z for side milling in steel < 900 N/mm ²	0.02 mm
large $\varnothing D_2$	4.6 mm
small $\varnothing D_3$	1.5 mm
Radius r	1.5 mm
Flute length L_c	1.5 mm
Machining strategy	HPC
Radius milling	forwards
Coating	TiAlN
Tool material	Solid carbide
Standard	Manufacturer's standard

Type	N
Tolerance of radius contour	± 0.01
Direction of infeed	horizontal
Shank	DIN 6535 HA to h6
Through-coolant	no
Shank tolerance	h6
Colour ring	without
Type of product	corner rounding cutter, HSS-Co5

User data

	Suitability	V _c	ISO code
Alu plastics	suitable	800 m/min	N
Aluminium (short chipping)	suitable	600 m/min	N
Alu > 10% Si	suitable	400 m/min	N
Steel < 500 N/mm ²	suitable	200 m/min	P
Steel < 750 N/mm ²	suitable	180 m/min	P
Steel < 900 N/mm ²	suitable	170 m/min	P
Steel < 1100 N/mm ²	Suitable	100 m/min	P
INOX < 900 N/mm ²	suitable	90 m/min	M
INOX > 900 N/mm ²	suitable	80 m/min	M
Uni	suitable		
wet maximum	suitable		
wet minimum	suitable only under restricted conditions		
dry	suitable		
Air	suitable		

Services

Shank grinding Type HB	129100 HB
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