

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

**Order data**

Order number	208023 1
GTIN	4062406103590
Item class	11X

**Description**
**Version:**
**Straight fluted, without profile distortion.**

Tolerance:  $r = \pm 0.01$  mm.

**Application:**

For rounding and deburring **edges**.

**Technical description**

large $\varnothing D_2$	8 mm
small $\varnothing D_3$	6 mm
Shank $\varnothing D_s$	8 mm
Feed $f_z$ for side milling in steel $< 900$ N/mm <sup>2</sup>	0.025 mm
No. of teeth Z	6
Flute length $L_c$	1 mm
Radius r	1 mm
Overall length L	70 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 <sub>c</sub>	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 <sup>2</sup>	suitable	200 m/min	P
Steel < 750 N/mm <sup>2</sup>	suitable	180 m/min	P
Steel < 900 N/mm <sup>2</sup>	suitable	170 m/min	P
Steel < 1100 N/mm <sup>2</sup>	suitable	100 m/min	P
INOX < 900 N/mm <sup>2</sup>	suitable	90 m/min	M
INOX > 900 N/mm <sup>2</sup>	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