

**Garant**
**GARANT Master Alu PickPocket solid carbide torus cutter HPC, DLC, Ø e8 DC/  
R1: 6/1,0mm**

**Order data**

|              |               |
|--------------|---------------|
| Order number | 206255 6/1,0  |
| GTIN         | 4062406156220 |
| Item class   | 11X           |

**Description**
**Version:**

Cutting edge length to DIN 6527.

All dimensions to DIN.

Tolerance: Corner radius  $R_1 = \pm 0.01$  mm.

**Application:**

Especially for **high speed machining** in **mould and tool making** for **copy milling**.

**Technical description**

|   |                   |
|---|-------------------|
| Corner radius $R_1$                                     | 1 mm              |
| Overall length L  | 57 mm             |
| Helix angle   | 42 degrees        |
| Feed $f_z$ for copy milling in short-chipping aluminium | 0.09 mm           |
| Balance quality with shank                              | G 2.5 with HA     |
| Feed $f_z$ for side milling in short-chipping aluminium | 0.08 mm           |
| No. of teeth Z  | 3                 |
| Shank   | DIN 6535 HA to h6 |
| Flute length $L_c$                                      | 13 mm             |
| Overhang length $L_1$ incl. recess                      | 19 mm             |
| Recess $\varnothing D_1$                                | 5.8 mm            |

|   |                                  |
|---|----------------------------------|
| Cutting edge $\varnothing D_c$            | 6 mm                             |
| Shank $\varnothing D_s$                   | 6 mm                             |
| Series                                    | Master Alu                       |
| Coating                                   | DLC                              |
| Tool material                             | Solid carbide                    |
| Standard                                  | DIN 6527                         |
| Type                                      | W                                |
| Tolerance nominal $\varnothing$           | e8                               |
| Helix angle characteristic                | unequal spacing                  |
| Spacing of the cutters                    | unequal spacing                  |
| Direction of infeed                       | horizontal, oblique and vertical |
| Cutting width $a_e$ for milling operation | 0.5×D for side milling           |
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| Through-coolant                           | no                               |
| Machining strategy                        | HPC                              |
| Shank tolerance                           | h6                               |
| Colour ring                               | yellow                           |
| Type of product                           | Torus cutter                     |

## User data

|                            | Suitability | $V_c$     | ISO code |
|----------------------------|-------------|-----------|----------|
| Alu plastics               | suitable    | 550 m/min | N        |
| Aluminium (short chipping) | suitable    | 500 m/min | N        |
| Alu > 10% Si               | suitable    | 450 m/min | N        |
| PMMA acrylic               | suitable    | 200 m/min | N        |
| PE-HD                      | suitable    | 160 m/min | N        |
| PA 66                      | suitable    | 200 m/min | N        |
| PEEK                       | suitable    | 150 m/min | N        |

|                    |   |           |   |
|--------------------|---|-----------|---|
| PF 31              | suitable                                  | 130 m/min | N |
| PVDF GF20          | suitable                                  | 180 m/min | N |
| POM GF25           | suitable                                  | 160 m/min | N |
| PA 66 GF30         | suitable                                  | 150 m/min | N |
| PEEK GF30          | suitable                                  | 130 m/min | N |
| PTFE CF25          | suitable                                  | 160 m/min | N |
| Honeycomb sandwich | suitable only under restricted conditions | 300 m/min | N |
| Cu                 | suitable                                  | 160 m/min | N |
| CuZn               | suitable                                  | 200 m/min | N |
| wet maximum        | suitable                                  |           |   |
| wet minimum        | suitable only under restricted conditions |           |   |
| dry                | suitable only under restricted conditions |           |   |
| Air                | suitable                                  |           |   |
| <b>Services</b>    |   |           |   |

Shank grinding Type HB

129100 HB