

**Garant**
**GARANT Master Alu PickPocket solid carbide torus cutter HPC, DLC, Ø e8 DC/  
R1: 20/5,0mm**

**Order data**

Order number	206255 20/5,0
GTIN	4062406156343
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**

Recess Ø $D_1$	19.8 mm
Balance quality with shank	G 2.5 with HA
Corner radius $R_1$	5 mm
Cutting edge Ø $D_c$	20 mm
Shank	DIN 6535 HA to h6
Feed $f_z$ for side milling in short-chipping aluminium	0.22 mm
Helix angle	42 degrees
Overall length L	104 mm
Flute length $L_c$	41 mm
Overhang length $L_1$ incl. recess	52 mm
Shank Ø $D_s$	20 mm

No. of teeth Z	3
Feed $f_z$ for copy milling in short-chipping aluminium	0.25 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